



**24" & 27"**  
**RESAW BANDSAWS**  
**MODELS G3619/G3620/G9963/G9966**  
**INSTRUCTION MANUAL**



Model G3919/G3620



Model G9963/G9966

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# WARNING

Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to the State of California to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- Lead from lead-based paints.
- Crystalline silica from bricks, cement, and other masonry products.
- Arsenic and chromium from chemically treated lumber.

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.

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# SECTION 1: SAFETY

## WARNING

### For Your Own Safety Read Instruction Manual Before Operating This Equipment

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words which are intended to convey the level of importance of the safety messages. The progression of symbols is described below. Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures.

#### DANGER

Indicates an imminently hazardous situation which, if not avoided, **WILL** result in death or serious injury.

#### WARNING

Indicates a potentially hazardous situation which, if not avoided, **COULD** result in death or serious injury.

#### CAUTION

Indicates a potentially hazardous situation which, if not avoided, **MAY** result in minor or moderate injury. It may also be used to alert against unsafe practices.

#### NOTICE

This symbol is used to alert the user to useful information about proper operation of the equipment.

## WARNING

### Safety Instructions For Power Tools

1. **KEEP GUARDS IN PLACE** and in working order.
2. **REMOVE ADJUSTING KEYS AND WRENCHES.** Form habit of checking to see that keys and adjusting wrenches are removed from tool before turning on.
3. **KEEP WORK AREA CLEAN.** Cluttered areas and benches invite accidents.
4. **DO NOT USE IN DANGEROUS ENVIRONMENT.** Do not use power tools in damp or wet locations, or where any flammable or noxious fumes may exist. Keep work area well lighted.
5. **KEEP CHILDREN AND VISITORS AWAY.** All children and visitors should be kept at a safe distance from work area.
6. **MAKE WORKSHOP CHILD PROOF** with padlocks, master switches, or by removing starter keys.
7. **DO NOT FORCE TOOL.** It will do the job better and safer at the rate for which it was designed.
8. **USE RIGHT TOOL.** Do not force tool or attachment to do a job for which it was not designed.

# **WARNING**

## **Safety Instructions For Power Tools**

- 9. USE PROPER EXTENSION CORD.** Make sure your extension cord is in good condition. Conductor size should be in accordance with the chart below. The amperage rating should be listed on the motor or tool nameplate. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating. Your extension cord must also contain a ground wire and plug pin. Always repair or replace extension cords if they become damaged.

Minimum Gauge for Extension Cords

AMP RATING	LENGTH		
	25ft	50ft	100ft
0-6	18	16	16
7-10	18	16	14
11-12	16	16	14
13-16	14	12	12
17-20	12	12	10
21-30	10	10	No

- 10. WEAR PROPER APPAREL.** Do not wear loose clothing, gloves, neckties, rings, bracelets, or other jewelry which may get caught in moving parts. Non-slip footwear is recommended. Wear protective hair covering to contain long hair.
- 11. ALWAYS USE SAFETY GLASSES.** Also use face or dust mask if cutting operation is dusty. Everyday eyeglasses only have impact resistant lenses, they are NOT safety glasses.
- 12. SECURE WORK.** Use clamps or a vise to hold work when practical. It is safer than using your hand and frees both hands to operate tool.
- 13. DO NOT OVERREACH.** Keep proper footing and balance at all times.
- 14. MAINTAIN TOOLS WITH CARE.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.

- 15. USE RECOMMENDED ACCESSORIES.** Consult the owner's manual for recommended accessories. The use of improper accessories may cause risk of injury.

- 16. REDUCE THE RISK OF UNINTENTIONAL STARTING.** On machines with magnetic contact starting switches there is a risk of starting if the machine is bumped or jarred. Always disconnect from power source before adjusting or servicing. Make sure switch is in OFF position before reconnecting.

- 17. MANY WOODWORKING TOOLS CAN "KICKBACK" THE WORKPIECE** toward the operator if not handled properly. Know what conditions can create "kickback" and know how to avoid them. Read the manual accompanying the machine thoroughly.

- 18. CHECK DAMAGED PARTS.** Before further use of the tool, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.

- 19. NEVER LEAVE TOOL RUNNING UNATTENDED. TURN POWER OFF.** Do not leave tool until it comes to a complete stop.

- 20. NEVER OPERATE A MACHINE WHEN TIRED, OR UNDER THE INFLUENCE OF DRUGS OR ALCOHOL.** Full mental alertness is required at all times when running a machine.

- 21. NEVER ALLOW UNSUPERVISED OR UNTRAINED PERSONNEL TO OPERATE THE MACHINE.** Make sure any instructions you give in regards to the operation of the machine are approved, correct, safe, and clearly understood.

## **WARNING**

# **Additional Safety Instructions For Bandsaws**

1. **DO NOT OPERATE WITH DULL OR BADLY WORN BLADES.** Dull blades require more effort to use and are difficult to control. Inspect blades before each use.
2. **NEVER POSITION FINGERS OR THUMBS IN LINE WITH THE CUT.** Serious personal injury could occur.
3. **DO NOT OPERATE THIS BANDSAW WITHOUT WHEEL, PULLEY, AND BLADE GUARDS IN PLACE.**
4. **WHEN REPLACING BLADES,** make sure teeth face down toward the table. The force of the cut is always down. Make sure the blade is properly tensioned after installing.
5. **CUTS SHOULD ALWAYS BE FULLY SUPPORTED** by the table or some type of support fixture. Always support round stock in a V-block.
6. **DO NOT BACK WORKPIECE AWAY** from the blade while the saw is running. Plan your cuts so you always cut out of the wood. If you need to back the work out, turn the bandsaw off and wait for the blade to come to a complete stop. Do not twist or put excessive stress on the blade while backing work away.
7. **BLADE SHOULD BE RUNNING AT FULL SPEED** before beginning a cut.
8. **ALWAYS FEED STOCK EVENLY AND SMOOTHLY.** Do not force or twist blade while cutting, especially when sawing small radii.
9. **THIS MACHINE IS NOT DESIGNED TO CUT METAL** or other material except wood.
10. **DO NOT MANUALLY STOP OR SLOW BLADE** after turning the saw off. Allow it to come to a complete stop before you leave it unattended.
11. **ALL INSPECTIONS, ADJUSTMENTS, AND MAINTENANCE ARE TO BE DONE WITH THE POWER OFF** and the plug pulled from the outlet. Wait for all moving parts to come to a complete stop.
12. **HABITS – GOOD AND BAD – ARE HARD TO BREAK.** Develop good habits in your shop and safety will become second-nature to you.
13. **IF AT ANY TIME YOU ARE EXPERIENCING DIFFICULTIES PERFORMING THE INTENDED OPERATION, STOP USING THE BANDSAW!** Then contact our service department or ask a qualified expert how the operation should be performed.

## **WARNING**

To operate this or any power tool safely and efficiently, it is essential to become as familiar with it as possible. The time you invest before you begin to use your bandsaw will be time well spent. **DO NOT** operate this machine until you are completely familiar with the contents of this manual or serious personal injury may occur.

## **CAUTION**

No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment or poor work results.

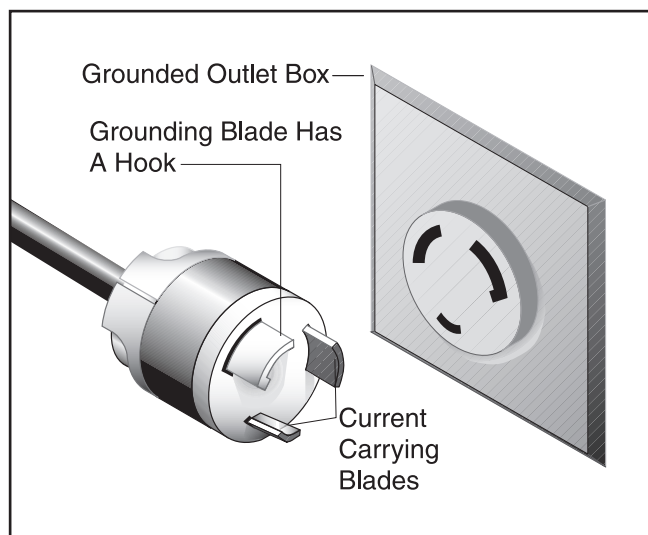
# SECTION 2: CIRCUIT REQUIREMENTS

## Model G3619

The Model G3619 Bandsaw is pre-wired for single-phase, 220V operation. Under normal use, the Model G3619 5 HP motor draws approximately 22 amps. We recommend a 30 amp circuit. This includes a 30 amp circuit breaker and wiring rated for at least 30 amps. This should be satisfactory for normal use, while providing enough protection against damage caused by an overloaded circuit. If frequent circuit failures occur when using the bandsaw, contact our service department or your local electrical contractor.

This bandsaw must be connected to its own dedicated circuit; it should not share a circuit with any other machine. A standard 2-pole breaker is necessary for use with the Model G3619.

This bandsaw is not supplied with a power plug. We recommend using a NEMA-style L6-30 plug and outlet similar to **Figure 1**. You may also “hard-wire” the bandsaw directly to your panel, provided you place a disconnect near the machine.



**Figure 1.** Typical 220V 3-prong plug and outlet.



## Model G9963

The Model G9963 Bandsaw is pre-wired for single-phase, 220V operation. Under normal use, the Model G9963 7.5 HP motor draws approximately 33 amps. We recommend using a 50 amp circuit. This includes a 50 amp circuit breaker and wiring rated for at least 50 amps. If frequent circuit failures occur when using the bandsaw, contact our service department or your local electrical contractor.

This bandsaw must be connected to its own dedicated circuit; it should not share a circuit with any other machine. A standard 2-pole breaker is necessary for use with the Model G9963.

This bandsaw is not supplied with a power plug. We recommend “hard-wiring” the bandsaw to the power source, provided you place a locking shut off switch near the machine to disconnect the power.



### CAUTION

Be sure that your particular electrical configuration complies with local and state codes. The best way to ensure compliance is to check with your local municipality or a licensed electrician.

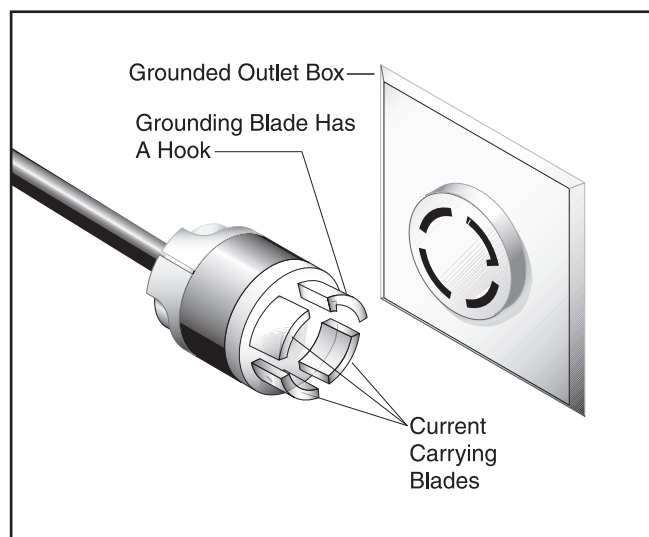


# Model G3620/G9966

The Model G3620/G9966 Bandsaw is pre-wired for 3-phase, 220V operation. Under normal use, the 7½ HP motor for this model draws approximately 19 amps. We recommend using a 25 amp circuit, including a 25 amp circuit breaker and wiring rated for at least 25 amps. If frequent circuit breaker failures occur when using the bandsaw, contact our service department.

This bandsaw must be connected to its own dedicated circuit. It should not share a circuit with any other machine. A standard 3-pole breaker is necessary for use with the Model G9963.

We recommend using a NEMA-style L15-30 plug and outlet, similar to **Figure 2**. You may also “hard-wire” the bandsaw directly to your panel, provided you place a disconnect near the machine. Check the electrical codes in your area for specifics on wiring requirements.



**Figure 2.** Typical plug configuration for 220V, three-phase operation.



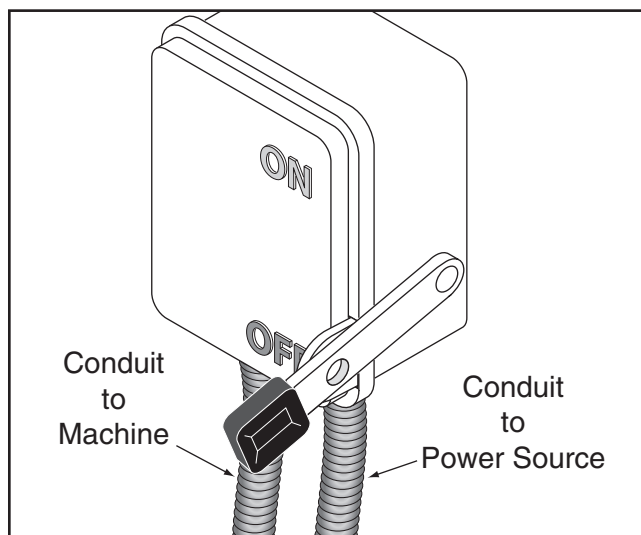
# 440V Operation

The Model G3620/G9966 Bandsaw is furnished with a 7½ HP 3-phase motor that can be wired to 440V. Under normal use, this motor draws approximately 10 amps at 440V. If 440V operation is desired, we recommend using a 15 amp circuit that includes the appropriate wiring and circuit breaker. If frequent circuit failures occur when using the bandsaw, contact our service department.

The bandsaw must be connected to its own dedicated 10A circuit. It should not share a circuit with any other machine. A standard 3-pole breaker is necessary for 440V use.

This bandsaw is not supplied with a power plug. We recommend “hard-wiring” the bandsaw to the power source, provided you place a locking shut off switch near the machine to disconnect the power. Check the electrical codes in your area for specifics on wiring requirements.

**If you convert the bandsaw to 440V, the stock mag switch must be replaced with a different mag switch specifically for 440V use. The 440 mag switch is not included with your bandsaw.**



**Figure 3.** Locking shut-off switch typically in a hardwire setup to disconnect power to machine.

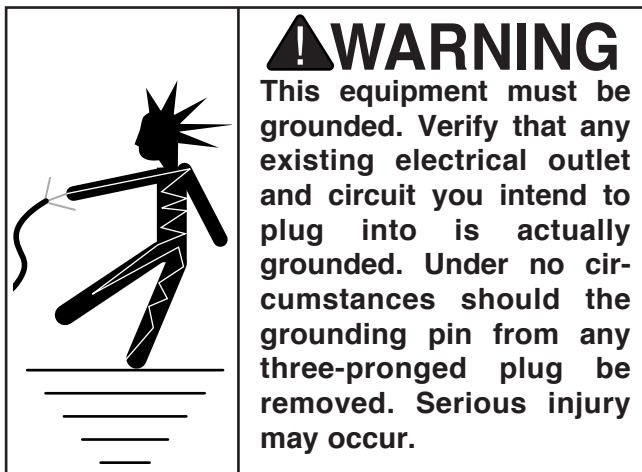




# Grounding

In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This tool is equipped with an electric cord having an equipment grounding conductor. A plug with a grounding pin must be plugged into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances.

Improper connections of the electrical-grounding conductor can result in risk of electric shock. The conductor with green or green and yellow striped insulation is the electrical grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment grounding conductor to a live terminal.



Under no circumstances should the grounding pin from any plug be removed. If it will not fit the outlet, have the proper outlet installed by a qualified electrician. Repair or replace damaged or worn cords immediately.

Check with a qualified electrician or one of our service personnel if the grounding instructions are not completely understood, or if you are in doubt as to whether the tool is properly grounded. Use only extension cords that have grounding type plugs and receptacles that accept the plug on the machine.



# Extension Cords

We do not recommend the use of extension cords on 220V or 440V equipment. It is much better to arrange the placement of your equipment and the installed wiring to eliminate the need for extension cords. Should it be necessary to use an extension, make sure the cord is rated Hard Service (Grade S) or better. Refer to the chart on **page 3** to determine the minimum gauge for the extension cord. The extension cord must also contain a ground wire and plug pin. Always repair or replace extension cords when they become worn or damaged.



## ! CAUTION

We have covered some basic electrical requirements for the safe operation of your bandsaw. These requirements are not necessarily comprehensive. You must be sure that your particular electrical configuration complies with local and state codes. Ensure compliance by checking with your local municipality or a licensed electrician.

# SECTION 3: GENERAL INFORMATION

## Commentary

Grizzly Industrial, Inc. is proud to offer the 24" and 27" Resaw Bandsaws. These bandsaws are a part of Grizzly's growing family of fine wood-working machinery. When used according to the guidelines stated in this manual, you can expect years of trouble-free, enjoyable operation, and proof of Grizzly's commitment to customer satisfaction.

The chart below has been provided to help identify the differences between the 24" and 27" Resaw Bandsaws

We are also pleased to provide this manual with the 24" and 27" Resaw Bandsaws. It was written to guide you through assembly, review safety considerations, and cover general operating procedures. It represents our latest effort to produce the best documentation possible. If you have any comments or criticisms that you feel we should address in our next printing, please write to us at:

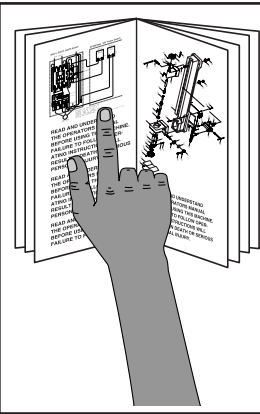
Grizzly Industrial, Inc.  
% Technical Documentation  
P.O. Box 2069  
Bellingham, WA 98227

Most important, we stand behind our machines. We have excellent regional service departments at your disposal should the need arise.

If you have any service questions or parts requests, please call or write to us at the location listed below.

Grizzly Industrial, Inc  
1203 Lycoming Mall Circle  
Muncy, PA 17756  
Phone:(570) 546-9663  
Fax:(800) 438-5901  
E-Mail: techsupport@grizzly.com  
Web Site: <http://www.grizzly.com>

The specifications, drawings, and photographs illustrated in this manual represent the 24" and 27" Resaw Bandsaws as supplied when the manual was prepared. However, owing to Grizzly's policy of continuous improvement, changes may be made at any time with no obligation on the part of Grizzly. Whenever possible, though, we send manual updates to all owners of a particular tool or machine. Should you receive one, we urge you to insert the new information with the old and keep it for reference.



**!WARNING**

Read the manual before assembly and operation. Become familiar with the machine and its operation before beginning any work. Serious personal injury may result if safety or operational information is not understood or followed.



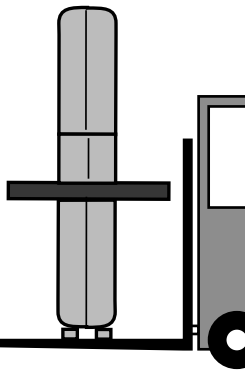
Description	G3619	G3620	G9963	G9966
Motor	5 HP	7½ HP	7½ HP	7½ HP
Phase	1-Phase	3-Phase	1-Phase	3-Phase
Size	24"	24"	27"	27"

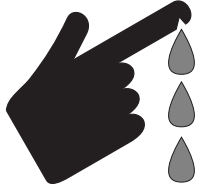
# Unpacking

The 24" and 27" Resaw Bandsaws are shipped from the manufacturer in a carefully packed crate. If you discover the machine is damaged after you have signed for delivery, *please call Customer Service immediately for advice.*

Save the containers and all packing materials for possible inspection by the carrier or its agent. *Otherwise filing a freight claim can be difficult.*

When you are completely satisfied with the condition of your shipment, you should inventory its parts.

	<p><b>⚠ WARNING</b></p> <p>The 24" and 27" Resaw Bandsaws are heavy machines. DO NOT over-exert yourself while unpacking or moving your machine – you will need assistance and power equipment. Serious personal injury may occur if safe moving methods are not followed.</p>
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	<p><b>⚠ CAUTION</b></p> <p>Some metal parts may have sharp edges on them after they are formed. Please examine the edges of all metal parts before handling them. Failure to do so could result in injury.</p>
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# Piece Inventory

After all the parts have been removed from the carton, you should have:

- Bandsaw Unit with Blade
- Table with Rail Attached
- Dust Port
- Fence
- Miter Gauge (G3619/G3620 only)
- Hardware Bag
  - (1) Allen Wrench 6mm
  - (1) Open-End Wrench 12/14 mm
  - (1) Open-End Wrench 21/23 mm
  - (1) Phillips Screwdriver

In the event that any non-proprietary parts are missing (e.g. nuts or washers), we would be glad to replace them, or for the sake of expediency, replacements can be obtained at your local hardware store.



# Clean Up

The unpainted surfaces are coated with a waxy oil to protect them from corrosion during shipment. Remove this protective coating with a solvent cleaner or citrus-based degreaser such as Grizzly's G7895 Degreaser. To clean thoroughly, some parts may need to be removed. **For optimum performance from your machine, make sure you clean all moving parts or sliding contact surfaces that are coated.** Avoid chlorine-based solvents as they may damage painted surfaces should they come in contact. Always follow the manufacturer's instructions when using any type of cleaning product.



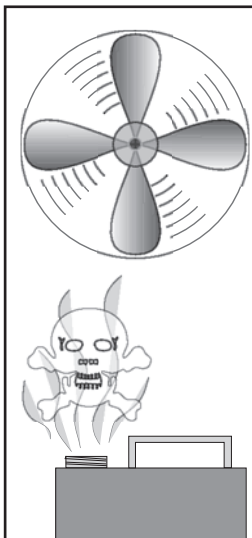
## ⚠️ WARNING

Do not use gasoline or other petroleum-based solvents to clean with. They have low flash points which make them extremely flammable. A risk of explosion and burning exists if these products are used.



## ⚠️ WARNING

Do not smoke while using solvents. A risk of explosion or fire exists and may result in serious personal injury.

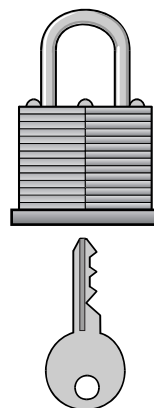


## ⚠️ CAUTION

Many of the solvents commonly used to clean machinery can be toxic when inhaled or ingested. Always work in well-ventilated areas far from potential ignition sources when dealing with solvents. Use care when disposing of waste rags and towels to be sure they do not create fire or environmental hazards.

# Site Considerations

- 1. Floor Load:** The 24" and 27" Resaw Bandsaws represent a large weight load in a small footprint. Most commercial floors are suitable for your machine. Some residential floors may require additional build up to support both machine and operator.
- 2. Working Clearances:** Consider existing and anticipated needs, size of material to be processed through each machine, and space for auxiliary stands, work tables or other machinery when establishing a location for your bandsaw.
- 3. Lighting and Outlets:** Lighting should be bright enough to eliminate shadow and prevent eye strain. Electrical circuits should be dedicated or large enough to handle amperage requirements. Outlets should be located near each machine so power or extension cords are clear of high-traffic areas. Observe local electrical codes for proper installation of new lighting, outlets, or circuits.

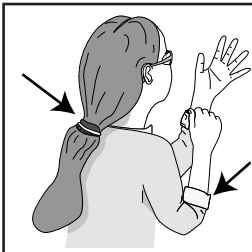


## ⚠️ CAUTION

Make your shop "child safe." Ensure that your workplace is inaccessible to children by closing and locking all entrances when you are away. Never allow visitors in your shop when assembling, adjusting, or operating equipment.

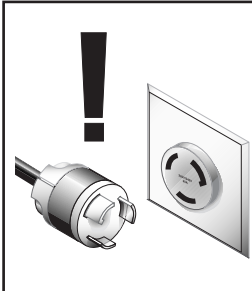


# SECTION 4: ASSEMBLY



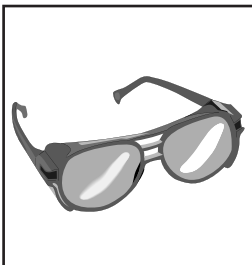
## ⚠️ WARNING

Keep loose clothing rolled up and out of the way of machinery and keep hair pulled back.



## ⚠️ WARNING

Keep power disconnected from machine when performing the assembly process. Failure to do this may result in serious personal injury.



## ⚠️ WARNING

Wear safety glasses during the entire assembly process. Failure to comply may result in serious personal injury.

## Beginning

The photos used in this manual are of the Model G9966. They are used for illustrative purposes only and any differences between the 24" and the 27" Bandsaws will be discussed in that particular section.

To complete the assembly process, follow the instructions in this section.



## NOTICE

When the fence is to the left of the blade, it must be positioned near the center of the table in order to open the lower wheel cover.

## Table

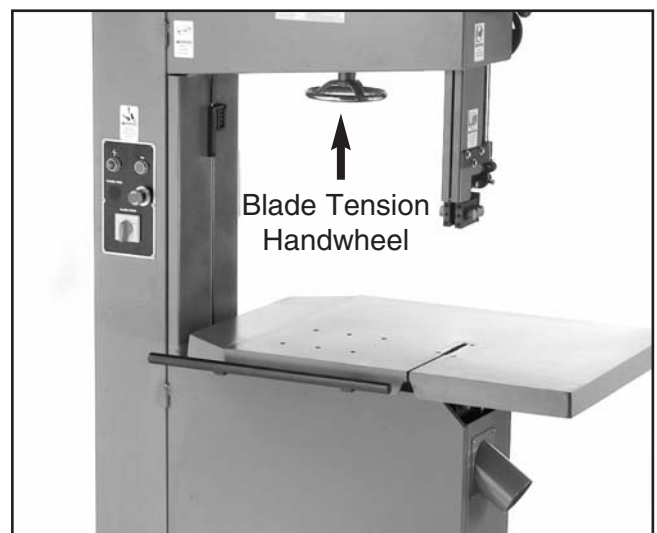


## ⚠️ CAUTION

The table for this bandsaw is very heavy. Get help when placing it on the trunnion.

To mount the table:

1. Installing the table is easiest if the blade is out of the way. Remove the blade by first loosening the blade tension handwheel, then by sliding it off the bandsaw wheels. Wear heavy leather gloves to protect your hands.
2. With the help of another person, lift the table onto the trunnion.
3. Place the large hex bolt with washer through the table trunnion mount and the trunnion. Do not tighten the bolt completely at this time. The assembly should now look similar to **Figure 4**.



**Figure 4.** Table installed correctly.



# Fence

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## To mount the fence:

1. Loosen the lock knob and slide the fence onto the rail.
2. Slide the fence beyond the center of the table so the blade can be installed without blocking the fence as shown in **Figure 5**.



**Figure 5.** Fence mounted on rail.

3. Slip the blade through the slot in the table and onto the bandsaw wheels, similar to how the blade was installed before you removed it. Make sure the blade teeth face downward during installation.
4. Tension the blade enough to keep it on the saw so it does not spring off during the rest of the assembly process.



# Dust Port

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## To install the dust port:

1. Place the dust port on the saw and install it with the included Phillips head screws as shown in **Figure 6**.

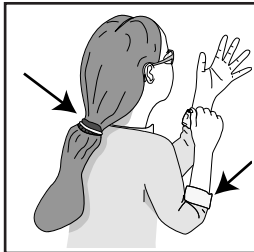


**Figure 6.** Dust port installed.



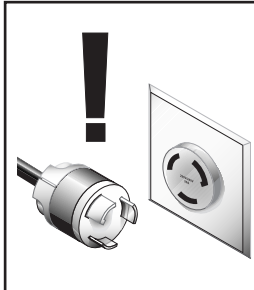


# SECTION 5: ADJUSTMENTS



## **!WARNING**

Keep loose clothing rolled up and out of the way of machinery and keep hair pulled back.



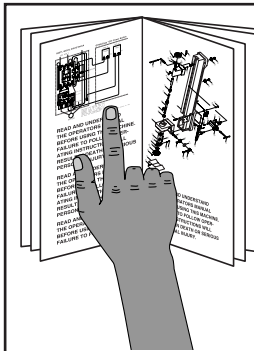
## **!WARNING**

Disconnect power to the machine when performing any adjustments. Failure to do this may result in serious personal injury.



## **!WARNING**

Wear safety glasses during the entire adjustment process. Failure to comply may result in serious personal injury.



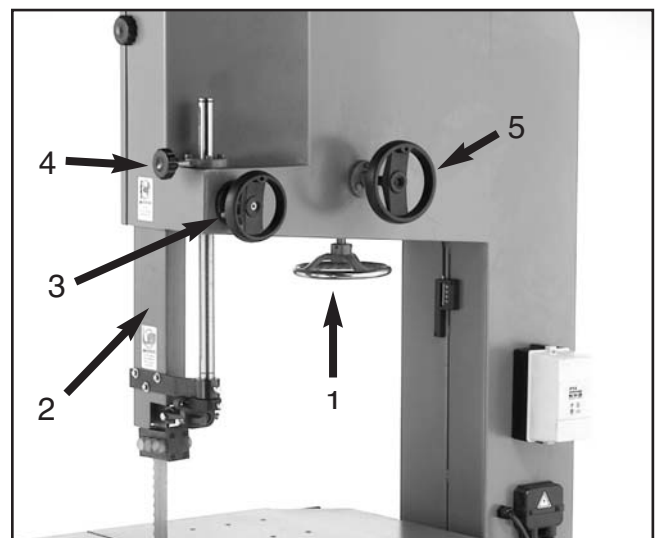
## **!WARNING**

Read through this entire manual to become familiar with the controls and the operations of the bandsaw before turning it on.

## Identification

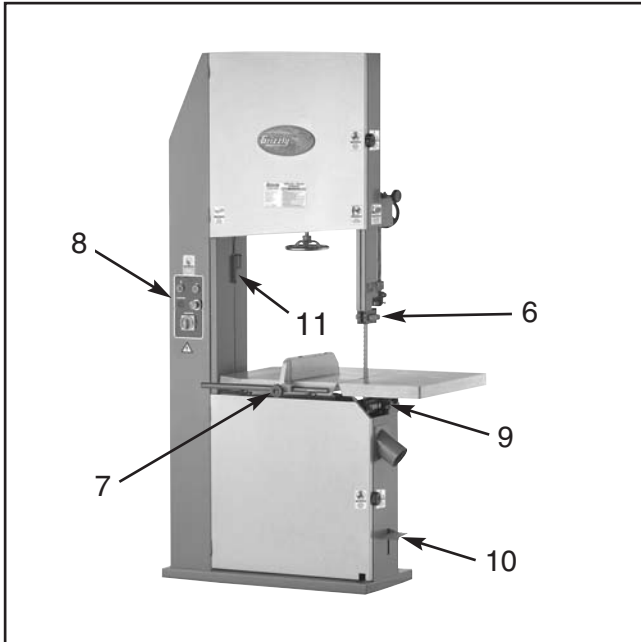
The 24" and 27" Resaw Bandsaw controls and components are frequently referred to in this section. Please take the time to identify the following controls and their locations shown in **Figures 7 and 8**:

1. Blade Tension Handwheel
2. Blade Guard
3. Guide Post Handwheel
4. Guide Post Lock Knob
5. Blade Tracking Handwheel
6. Upper Blade Guide Assembly
7. Fence Lock Knob
8. Control Panel
9. Table Tilt Control
10. Emergency Stop Brake
11. Blade Tensioning Scale



**Figure 7.** Rear view of bandsaw.





**Figure 8.** Front view of bandsaw.



## Guide Post

The rack and pinion guide post can be easily raised and lowered by first loosening the lock knob, then turning the guide post handwheel. Because the blade guard and the entire upper blade guide assembly are attached to the guide post, these items move up or down with the guide post.

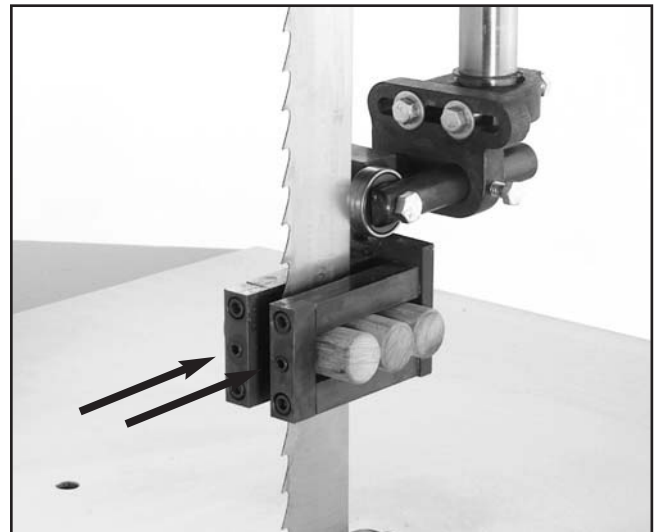


## Blade Guides

Always adjust the blade guides away from the blade before installing a new blade or making blade tracking/tension adjustments.

### G9963/G9966 Blade Guides

To move the assemblies out of the way, loosen the middle cap screws (shown in **Figure 9**) from the front of the blade guide assembly. These screws loosen the guide blocks which can then slide out of the way of the blade. After the blade tension and the blade tracking are set correctly, follow the “Guide Block” and “Support Bearing” instructions in this section for adjustment details.



**Figure 9.** For Model G9963/G9966 loosen middle cap screws on both sides to move the blade guides.

### G3619/G3620 Blade Guides

To move the guide blocks away from the blade, unscrew the knurled lock nuts on the guide block shaft and rotate the guide blocks away from the blade.



# G3619/G3620 Tracking

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The wheels on the Model G3619/G3620 Resaw Bandsaws are crowned with rubber tires. This style requires center tracking for proper operation.

## To center track your blade:

1. Make sure the bandsaw is unplugged!
2. Open the upper wheel cover door. Slowly rotate the upper wheel and watch where the blade rides on the wheel. If the blade stays centered on the crown of the wheel, then it is properly tracked.
3. If the blade does not ride centered on the crown of the wheel, then spin the upper wheel by hand and adjust the tracking hand-wheel until the blade is positioned correctly.
4. Spin the wheel approximately three more times to ensure that the blade stays centered. Adjust and check if necessary.
5. Close the upper wheel cover door.



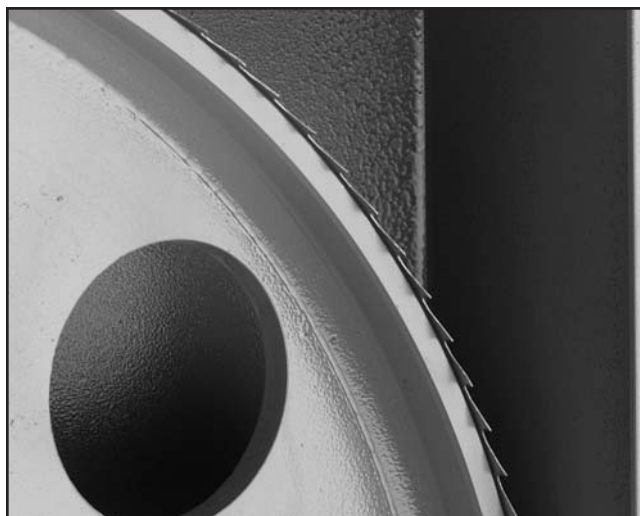
# G9963/G9966 Tracking

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The wheels on the Model G9963/G9966 Resaw Bandsaws are considered "Flat Wheels." This means that tracking procedures vary from the common crowned wheel bandsaws, because they do not have to be centered for proper operation.

## To track the blade:

1. Make sure the bandsaw is unplugged!
2. Open the wheel cover doors and check the position of the blade on the wheels. The teeth of the blade should be over the edge of each wheel. Ideally, the bottom of the teeth gullets should ride approximately  $\frac{1}{16}$ " off the edge of the wheels as shown in **Figure 10**.



**Figure 10.** Bottom of teeth gullets protruding  $\frac{1}{16}$ " from the edge of the upper wheel.

3. Turn the upper wheel clockwise by hand and watch the blade ride on the wheels. If the bottom of the blade gullets are not approximately  $\frac{1}{16}$ " away from the edge of the wheels then you need to adjust the tracking handwheel on the backside of the saw.
4. Turn the tracking handwheel a few times and note the direction that the blade shifts when you spin it by hand.
5. Adjust the tracking handwheel until the blade gullets ride approximately  $\frac{1}{16}$ " away from the edge of the wheels while you are spinning the upper wheel by hand. Your saw is now properly tracked.



## Support Bearings

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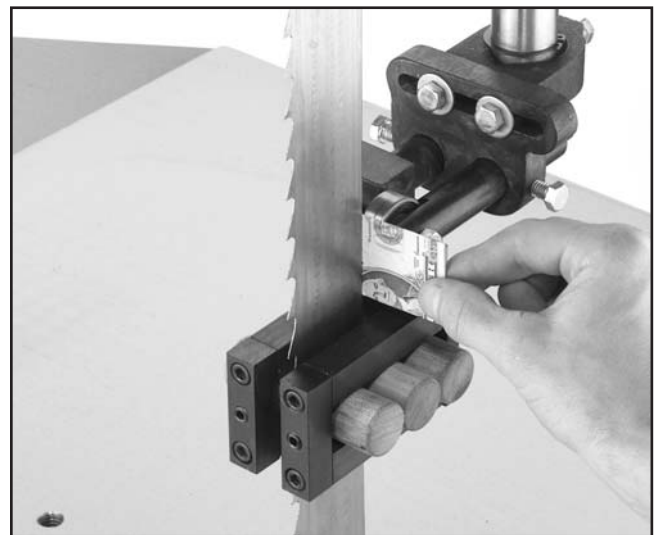
The support bearings back-up the blade during the sawing operation. The important adjustments to make with the support bearings are centering them laterally and adjusting the distance between the support bearing and the back of the blade.

### To center the support bearings laterally:

1. Loosen the two hex bolts that allow the upper assembly to move side-to-side.
2. Shift the entire assembly so the blade is centered on the support bearing.
3. Tighten the two hex bolts.

### To adjust the support bearings behind the blade:

1. Loosen the hex bolt that secures the support bearing shaft in place.
2. Adjust the support bearing shaft so it is approximately .016" away from the back of the blade. Four thicknesses of a dollar bill is approximately the equivalent to .016". For a quick gauge, fold a dollar bill in half twice.
3. Slip your folded dollar between the back of the blade and the support bearing as shown in **Figure 11**. Lightly pinch the folded dollar with the support bearing and secure the support bearing shaft in place.
4. Remove the folded dollar bill.



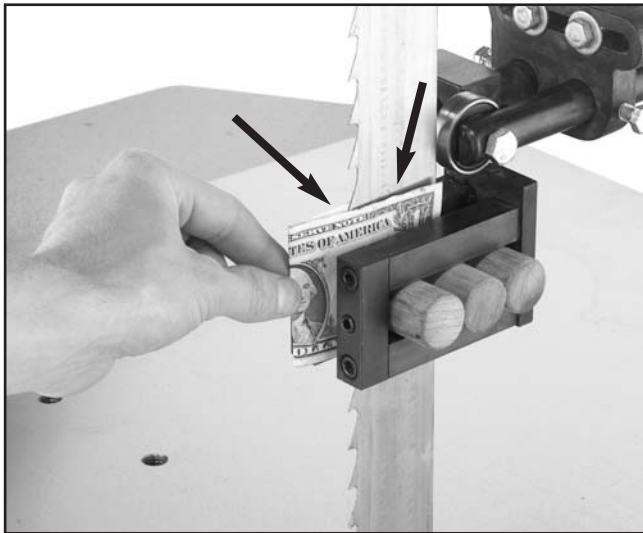
**Figure 11.** Folded dollar between support bearing and blade.



# Guide Blocks

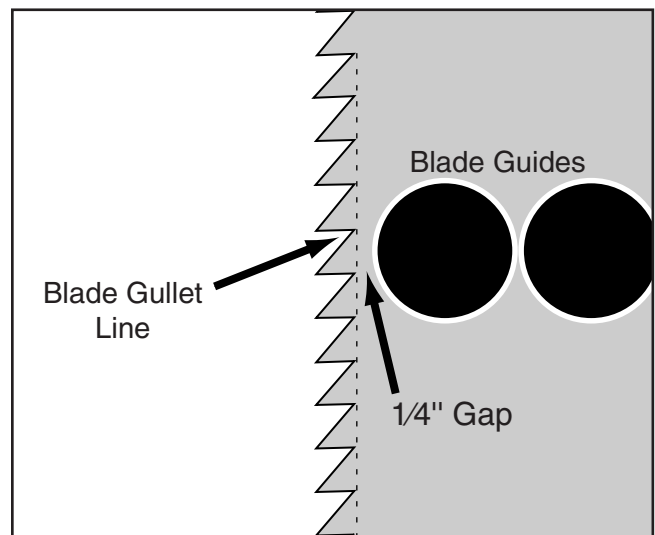
The guide blocks ensure that the blade cannot move side-to-side too far during operation. Perform **steps 1-4** for both upper and lower guide blocks.

1. Loosen the guide blocks from the center setscrew in the guide bracket.
2. The guide blocks should be approximately .004" away from the blade. This number is approximately the same as the single thickness of a dollar bill.
3. Fold a dollar bill once and slide it over the blade so each side is between blade and the blade guides as shown in **Figure 12**.



**Figure 12.** Single thickness of a dollar on each side of the blade.

4. Lightly pinch the dollar between the blade guides and the blade. Secure the cap screw to lock the blade guides in place.
5. Loosen the hex bolt that secures the blade guide shaft to the guide post collar. Adjust the blade guide assembly either forward or backward, so the front blade guide is positioned not more than  $\frac{1}{4}$ " behind the bottom of the blade gullet as illustrated in **Figure 13**.
6. Tighten the blade guide shaft hex bolt.



**Figure 13.** Blade guides not more than  $\frac{1}{4}$ " behind blade gullet.

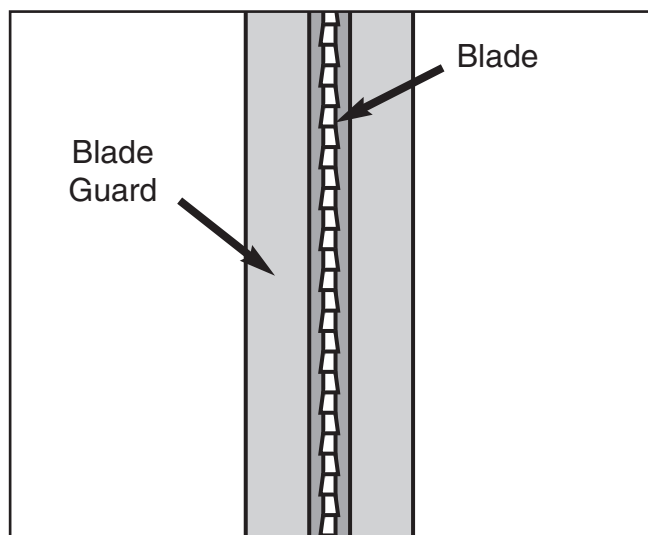


# Blade Guard

The blade guard is attached to the guide post above the upper blade guide assembly. For proper setup, the blade should be centered in the blade guard.

## To center the blade guard:

1. Loosen the hex bolt that secures the blade guard bracket to the guide post.
2. Rotate the blade guard bracket in the appropriate direction until the blade guard is centered around the blade as illustrated in **Figure 14**.
3. Tighten the hex bolt that secures the blade guard bracket to the guide post.



**Figure 14.** Blade centered in blade guard.



# Table Stop

The positive stop under the table (**see Figure 15**) allows you to repeatedly square up the table after adjusting the table tilt. To adjust the positive stop so the table will return perpendicular (90°) to the blade after angle cutting:

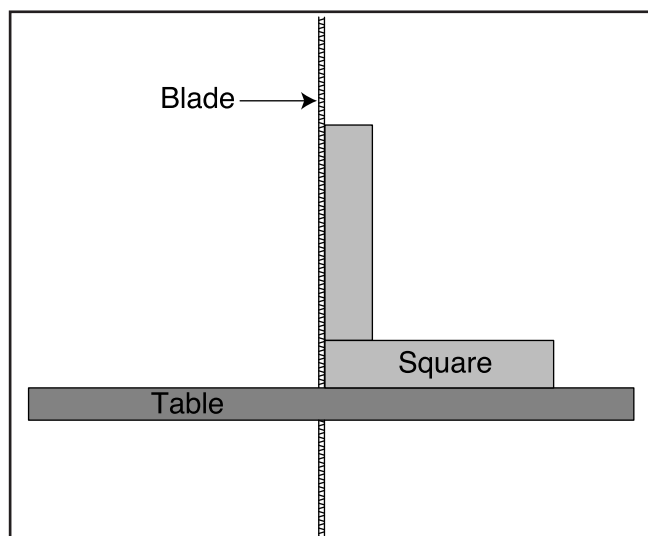
1. **Make sure the bandsaw is unplugged!**



**Figure 15.** Positive stop.

A warning icon featuring a large exclamation mark above a three-prong electrical plug.	<p><b>! WARNING</b></p> <p>Always disconnect power to the machine when making adjustments. Failure to do this may result in serious personal injury.</p>
--	--

2. Loosen the large hex bolt and the jamnut in the center of the table trunnion.
3. Raise the upper blade guide assembly and place a 6" machinist's square on the table against the blade as shown in **Figure 16**. Notice how far out of square your table is and approximate this distance by adjusting the positive stop up or down. Turning the positive stop counterclockwise will raise it and clockwise will lower it. Adjust the positive stop so the table will stop at a 90° angle (square) to the blade.
4. Lock the positive stop by tightening the jamnut. Do not let the stop turn while tightening the jamnut. Tighten the large hex nut in the center of the table trunnion.
5. Set the angle pointer to zero on the table tilt gauge.



**Figure 16.** Squaring table to blade.



## Table Tilt

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### To tilt the table:

1. **Disconnect power to the bandsaw!**
2. Loosen the large hex bolt in the center of the table trunnion.
3. Tilt the table to the desired angle. Refer to the angle gauge.
4. Tighten the large hex bolt in the center of the table trunnion.



## WARNING

The rest of the adjustments in this section require you to start the bandsaw. Before starting the bandsaw, make sure you have performed the preceding assembly and adjustment instructions, and you have read through the rest of the manual and are familiar with the various functions and safety issues associated with this machine. Failure to follow this warning may result in serious personal injury or even death!

## Test Run

Turn on the power supply at the main panel. Push the *START* button to turn on the bandsaw. Make sure that your hand is poised over the switch in case there is a problem. The bandsaw should run smoothly with little or no vibration or rubbing noises. If strange or unnatural noises are immediately apparent, press the *STOP* button. Investigate and correct before operating the machine further.

If you cannot easily locate the source of an unusual noise or vibration, feel free to contact our service department for help.



## Blade Tension

Proper blade tension is essential to any cutting operation on the bandsaw. Any time you change blades or remove a blade, you must re-adjust the tension.

### To adjust the tension:

1. Loosen the upper and lower guide blocks. Tighten them down and away from the blade *BEFORE* turning *ON*.
2. Lower the upper guide block assembly down to the table and tighten.
3. With moderate tension already on the blade, turn the bandsaw *ON*.
4. If you see the blade start to flutter, increase the tension until the blade stops fluttering, then tighten the tension handle an additional half turn.

If the blade does not flutter, decrease the tension until it begins to flutter, then tighten just to the point that it stops fluttering. Now tighten the tension handle an additional half turn.

5. Turn the bandsaw *OFF* and make the other adjustments in this section. Also, check the tracking and blade guides to make sure that they did not change after tensioning the blade.

If the blade does not cut properly, the tension may be incorrect. Re-adjust the tension.

After setting the tension, make a note of what the tension gauge reads. Use this to go back to your tension setting during later tensioning and retensioning with that particular blade.

Keep in mind that blades will last longer if you release the tension after every use. Also, new blades will often stretch with use. A tension that worked well when a blade was new may not work as well after the blade has been used.





# Fence Adjustment

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The fence slides along the rail for adjustment and secures in place by tightening the star knob.

If you notice that the fence is not parallel to the blade, it can be adjusted where the rail mounts to the bottom of the table.

## To adjust the fence so it is parallel with the blade:

1. With a different saw, cut a board to 1" x 4" x 28". Down the length of the board, joint one edge perfectly straight, or rip a narrow strip off the length of the board with a table saw.
2. On a wide face of the board, draw a straight line parallel to the jointed/ripped edge.
3. Slide the bandsaw fence out of the way and cut free-hand along the line. Stop at the halfway point. Turn the bandsaw *OFF* and *wait for the blade to stop*.
4. Clamp the board to the bandsaw table without moving it. Now slide the fence over to the board so it barely touches one end of the board.
5. Loosen the two hex bolts that secure the fence rail to the underside of the table.
6. Skew the fence left or right so it is parallel to the edge of the scrap piece. You may need to re-adjust the fence locking mechanisms to gain maximum adjustment.
7. While maintaining the skew, tighten the rail mounting bolts.
8. Make a few cuts using the fence. If the fence still does not seem parallel to the blade, read the "Blade Lead" instructions, or repeat **steps 1-7** until the blade and fence are parallel with each other.



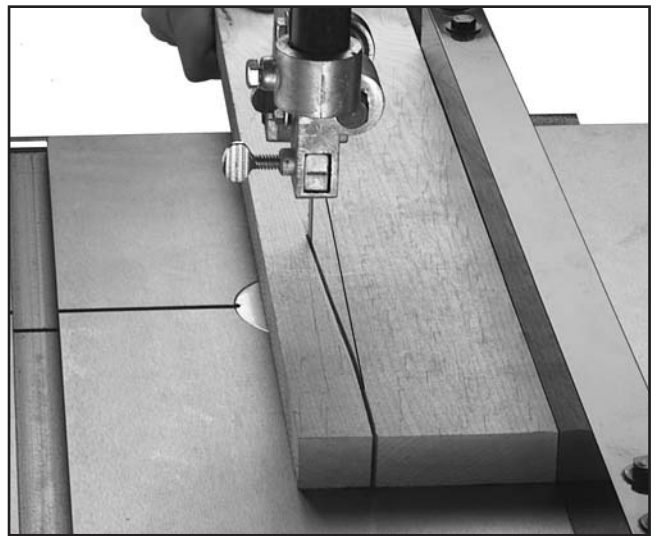
# Blade Lead

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Sometimes the bandsaw blade will not cut straight even when the fence and blade are parallel (**see Figure 17**). This condition is called "lead." Lead occurs (1) if the blade tension is incorrect, (2) if the teeth are dull on one side, or (3) if the teeth are set heavier on one side of the blade than the other.

If you determine that your blade is causing lead problems, you should consider:

- Checking/adjusting the blade tension
- Replacing the blade
- Sharpening the blade
- Skewing the fence to match the lead
- Attaching an aftermarket or shop made resaw fence attachment.



**Figure 17.** Typical example of blade leading away from line of cut.

## NOTICE

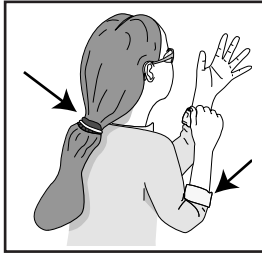
If the table is shifted, the fence will be affected since it is attached.

## NOTICE

Lead adjustments will change when new blades are mounted in the saw.

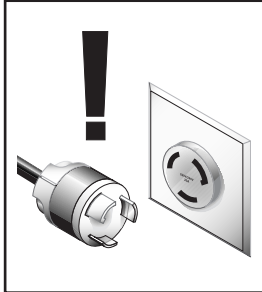


# SECTION 6: OPERATIONS



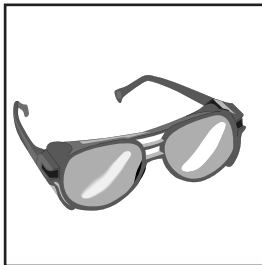
## **!WARNING**

Keep loose clothing rolled up and out of the way of machinery and keep hair pulled back.



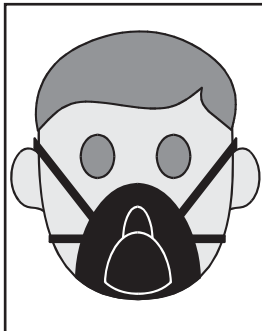
## **!WARNING**

Disconnect power to the machine when performing any maintenance or assembly. Failure to do this may result in serious personal injury.



## **!WARNING**

Wear safety glasses during the entire operation process. Failure to comply may result in serious personal injury.



## **!CAUTION**

Using this machine produces sawdust which may cause allergic reactions and respiratory problems. Use an approved dust mask to protect yourself from these hazards!

## **NOTICE**

The following section was designed to give instructions on the basic operations of this bandsaw. However, it is in no way comprehensive of every bandsaw application. There are many different jigs that can be built to increase safety, accuracy, and types of cuts. WE STRONGLY RECOMMEND that you read books, trade magazines, or get formal training to maximize the potential of your machine.

## Blade Selections

Selecting the right blade requires a combination of the various blade characteristics mentioned below, the type of material you plan to cut, and the type of cut you are going to perform.

### Blade Length

Measured by the circumference, blade lengths are usually unique to the model of your bandsaw and the wheel diameter. The Model G3619/3620 is designed for blades that are 175" long. The Model G9963/G9966 requires blades that are 206 $\frac{3}{4}$ " long.

### Blade Width

Measured from the the back of the blade to the tip of the blade tooth (the widest point), blade width is often the first consideration given to blade selection.

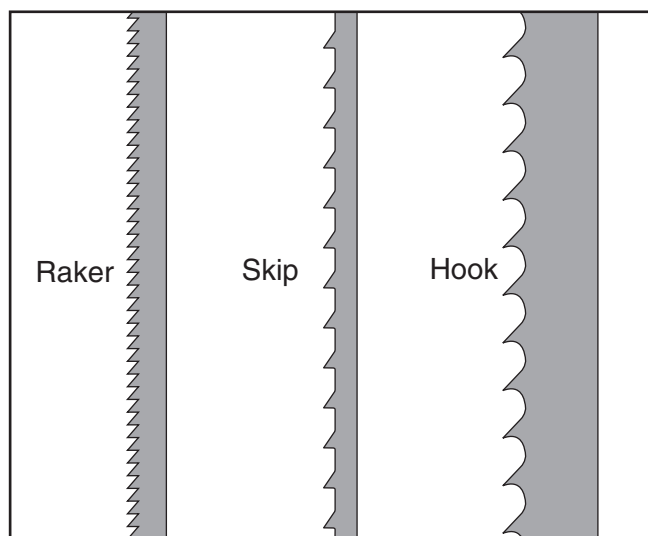
A narrow blade can cut tight curves (a small radius) but is not very good at cutting straight lines, because they naturally wander (blade lead). However, larger blades are much better at cutting straight lines and this makes them a natural choice for resawing applications

The 24" & 27" Resaw Bandsaws function best with blades that are 2" or 3" wide. Refer to the current Grizzly catalog for prices and ordering information. Always pick the size of blade that best suits your application.

### Tooth Style

When selecting blades, another option to consider is the shape, gullet size and angle of the teeth—otherwise known as "Tooth Style."

**Figure 18** shows the three main categories of tooth style.



**Figure 18.** Raker, Skip and Hook blades.

- **RAKER** — This style is considered to be the standard because the tooth size and shape are the same as the tooth gullet. The teeth on Raker blades are usually very numerous, have no angle, and produce cuts by scraping the material; these characteristics result in very smooth cuts, but at the same time do not cut fast and generate more heat while cutting. These blades also work well for cutting curves.
- **SKIP** — This style is like a raker blade that is missing every other tooth. Because of the design, skip toothed blades have a much larger gullet than raker blades, and therefore, cut faster and generate less heat. However, these blades also leave a rougher cut than raker blades. Great for resawing and ripping thin stock.
- **HOOK** — The teeth on this style have a positive angle (downward) which makes them dig into the material, and the gullets are usually rounded for easier waste removal. These blades are excellent for the tough demands of resawing and ripping thick stock.

### Tooth Pitch

Usually measured as T.P.I. (teeth per inch), tooth pitch determines the size of the teeth. More teeth

per inch (fine pitch) will cut slower, but smoother; while fewer teeth per inch (coarse pitch) will cut rougher, but faster. As a general rule, choose blades that will have at least three, but not more than twelve teeth in the material at all times. Use fine pitched blades on harder woods and coarse pitched blades on softer woods.

### Blade Care

A bandsaw blade is a delicate piece of steel that is subjected to tremendous strain. You can obtain longer use from a bandsaw blade if you give it fair treatment and always use the appropriate feed rate for your operation.

Be sure to select blades with the proper width, style, and pitch for each application. The wrong choice of blades will often produce unnecessary heat which will shorten the life of your blade.

A clean blade will perform much better than a dirty blade. A dirty blade passes through the cutting material with much more resistance than a clean blade. This extra resistance will also cause unnecessary heat. Maintain your blades with a cutting blade lubricant like SLIPIT® (Model G5562/3 in the Grizzly Catalog).

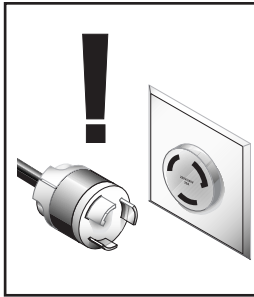
### Blade Breakage

Many conditions may cause a bandsaw blade to break. Blade breakage is unavoidable, in some cases, since it is the natural result of the peculiar stresses that bandsaw blades are subjected to. Blade breakage is also due to avoidable circumstances. Avoidable breakage is most often the result of poor care or judgement on the part of the operator when mounting or adjusting the blade or support guides.

The most common causes of blade breakage are: (1) faulty alignment or adjustment of the guides, (2) forcing or twisting a wide blade around a curve of short radius, (3) feeding too fast, (4) tooth dullness or absence of sufficient set, (5) excessive tension, (6) top blade guide assembly set too high above the work piece, (7) using a blade with a lumpy or improperly finished braze or weld and (8) running the bandsaw when not in use.



# Blade Changes



## **WARNING**

Always disconnect power to the machine when changing blades. Failure to do this may result in serious personal injury.

### To remove the blade:

1. After making sure the bandsaw is unplugged, release the tension on the blade by turning the tension control knob counter-clockwise.
2. Adjust the upper and lower guide blocks away from the blade.
3. Put on leather gloves to protect your hands from the sharp teeth of the blade.
4. Open the upper and lower wheel covers and slide the blade off both wheels. Use caution—the blades are sharp!

## **CAUTION**

Wear gloves and safety goggles when handling blades. Coiled blades spring open as they are uncoiled and could cause deep cuts or lacerations.

### To replace the blade:

1. Slide the blade through the table slot, ensuring that the teeth are pointing down toward the table.

If the teeth will not point downward in any orientation, the blade is inside-out. Put on heavy gloves, remove the blade, and twist it rightside-out.

2. Slip the blade through the upper and lower guides, and mount it over the upper and lower wheels so the blade teeth are over the edge of the wheels.
3. Apply tension, then check and adjust tracking.
4. Adjust the upper and lower guide blocks and support bearings.
5. Close and latch the wheel covers.



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# Ripping

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Ripping is the process of cutting a wide board into two or more thinner boards. **See Figure 19.** The maximum board width that can be ripped is limited by the maximum throat dimension of the bandsaw.

For ripping, a wider blade is better. In most ripping applications, a standard raker tooth style will be sufficient. Also, since most ripped lumber will be jointed smooth, you can choose blades with fewer teeth-per-inch.

## To perform ripping operations:

1. The bandsaw must be adjusted correctly. See “Blade Tension/Tracking” instructions and “Fence Adjustment” instructions.
2. Adjust the blade guard so it is just above the workpiece with a minimum amount of blade exposed. Read instructions on “Blade Lead” before making a cut.
3. Use a fence to guide the work. Set the distance between the fence and the blade to the desired width.
4. Support the ends of the board if necessary.
5. Feed the work slowly and evenly with the straightest edge against the fence.



**Figure 19.** Typical ripping operation.



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# Stacked Cuts

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One of the benefits of a bandsaw is its ability to cut multiple copies of a particular shape by stacking a number of workpieces together.

Before making stacked cuts, it is essential to ensure that both the table and the blade are properly adjusted to 90°. Otherwise, any error will be compounded with each piece from the top to the bottom of the stack.

## To complete a stacked cut:

1. Align your pieces from top to bottom to ensure that each piece has adequate scrap to provide a clean, unhampered cut.
2. Secure all the pieces together using brad nails through the waste portion or using beads of hot glue across the outside edges.
3. Lay out the shape you intend to cut on the face of the top piece.
4. Adjust the blade guard so it is just above the workpiece with a minimum amount of the blade exposed. One inch is ideal.
5. Make relief cuts perpendicular to the outline of your intended shape in areas where changes in blade direction could strain the blade.
6. Cut the stack of pieces as though you were cutting a single piece. Follow the layout line with the blade kerf on the waste side of your line.



# Resawing

---

Resawing is the process of cutting the thickness of a board into two or more thinner boards. Each new board is the same width and length as the original board, but the thickness is less. The maximum board width that can be resawn is limited by the maximum cutting height of the bandsaw.

The most important consideration when resawing is blade selection. When selecting a blade, keep in mind that generally a wider blade is easier to control.

In most applications a hook or skip tooth style will work fine. Also, since most resawn lumber will be planed smooth, you can choose blades with fewer teeth per inch (3 to 6). While blades with fewer teeth per inch produce rougher cuts, these types of blades offer larger gullet capacities for clearing sawdust, they produce less heat, and they yield more horsepower per tooth.

**To resaw lumber, follow the procedure below:**

1. The blade must be adjusted correctly for tension and tracking.
2. The fence must be square to the blade.
3. Adjust the blade guard so it is just above the workpiece with a minimum amount of blade exposed.
4. Use the widest blade that will fit your bandsaw. (Use the data sheets in the back of this manual to determine the maximum blade width for your saw.) The blade must also be sharp and in good condition. Read “Blade Lead” instructions.
5. Use the fence to guide the work.
6. Support the ends of the board if necessary.
7. Feed the work slowly and evenly.

## **WARNING**

**Do not force the wood into the blade during cutting. This will distort the blade, cause excessive heat and often results in blade breakage. Breakage can cause lacerations, cuts, or serious personal injury.**

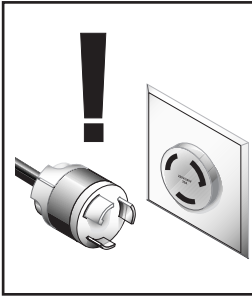
When resawing, consider using an auxiliary fence that is higher than the standard fence. This provides a more solid surface for the workpiece to slide against. An auxiliary fence can be made from any straight and flat piece of lumber and can be bolted or screwed to the standard fence.

When using a fence to guide the board, the actual line of cut may not be exactly parallel to the fence. This is due to a number of reasons involving the configuration of the table, condition of the blade, the cutting forces, and the blade tension. To correct this condition, refer to the “Blade Lead” instructions.





# SECTION 7: MAINTENANCE



## **WARNING**

**Always disconnect power to the machine when performing maintenance. Failure to do this may result in serious personal injury.**

## V-Belts

To ensure optimum power transmission from the motor to the blade, the V-belt must be in good condition and operate under proper tension. The belts should be checked for cracks, fraying and wear. Belt tension should be checked at least every 3 months; more often if the bandsaw is used daily.

The V-belt is accessed via the bottom cover. Squeeze the center of the V-belt. Note the amount of deflection. Deflection should be approximately  $\frac{3}{4}$ ".



## Miscellaneous

Always be aware of the condition of your bandsaw. Routinely check the condition of the following items and repair or replace as necessary:

- Loose mounting bolts
- Worn switch
- Worn or damaged blade
- Worn or damaged support bearings or guide bearings



## Table

The table and other non-painted surfaces on the 24" and 27" Resaw Bandsaws should be protected against rust and pitting. Wiping the saw clean after every use ensures that wood dust is not allowed to trap moisture against bare metal surfaces.

Tables can be kept rust-free with regular applications of products like SLIPIT®. For long term storage you may want to consider products like Boeshield® T-9. See the current Grizzly catalog for these products.



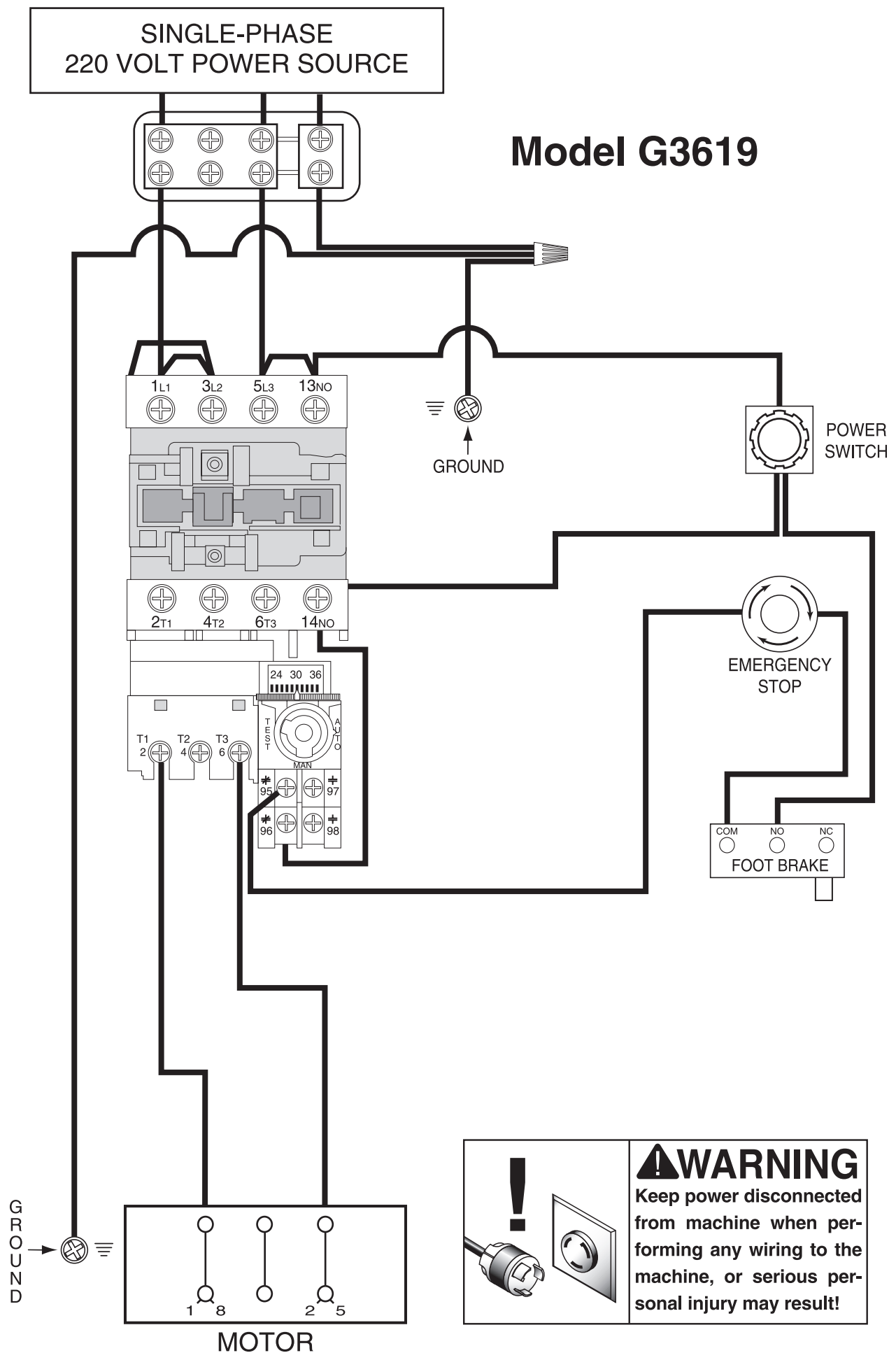
## Lubrication

Sealed and pre-lubricated ball bearings require no lubrication for the life of the bearings. All bearings are standard sizes, and replacements can be purchased from our parts department or bearing supply store.

As for other items on this machine, such as adjustment controls, an occasional "shot" of light oil is just about all that is necessary. Before applying, however, wipe off any sawdust with a clean cloth or dry paint brush, and spray on the lubricant. Ensure that oil does not get on the pulleys or V-belt because it could cause belt deterioration and slipping.

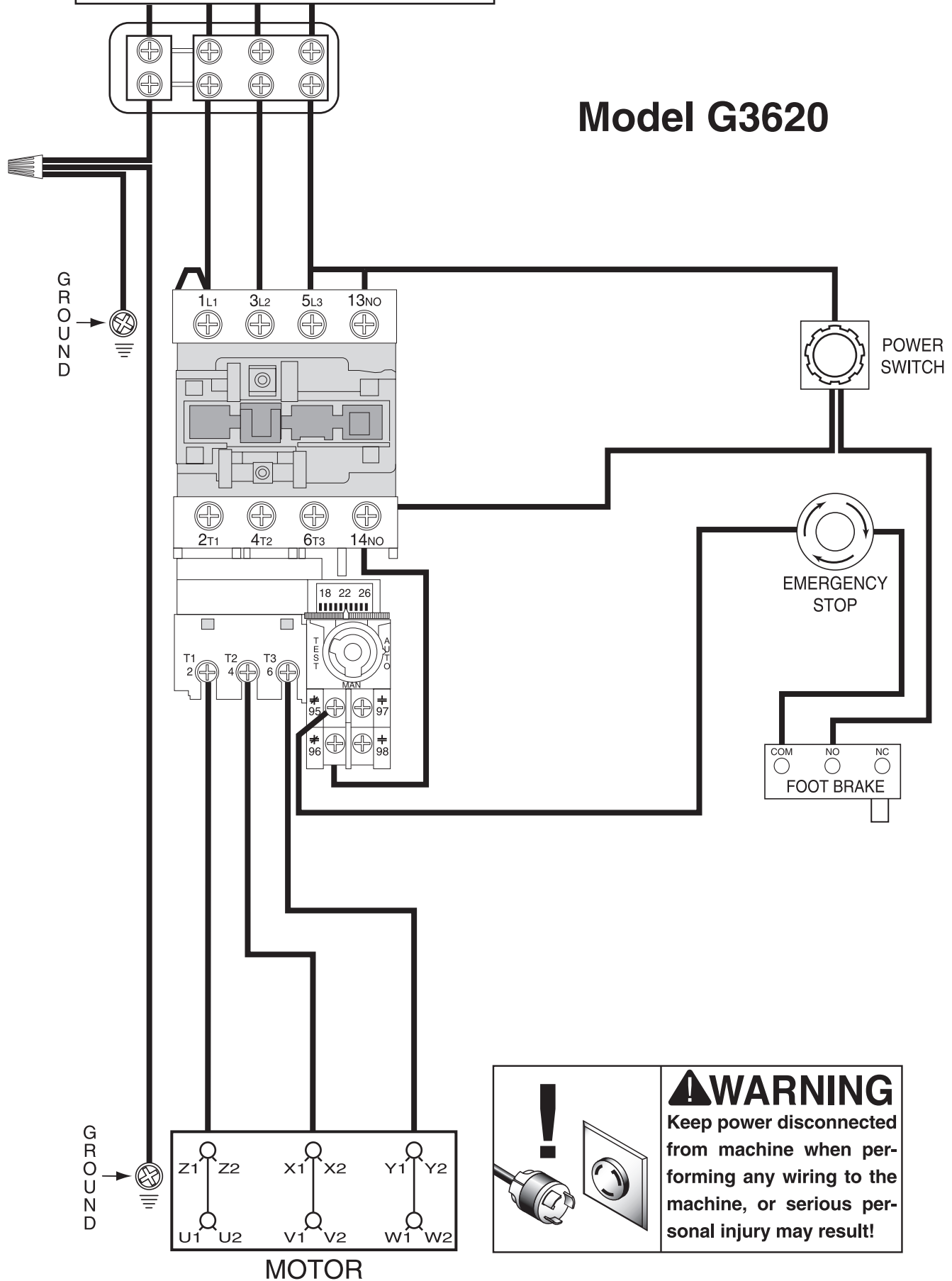






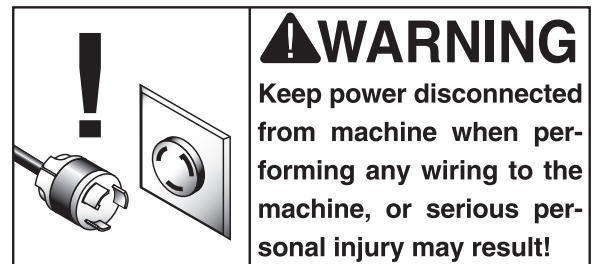
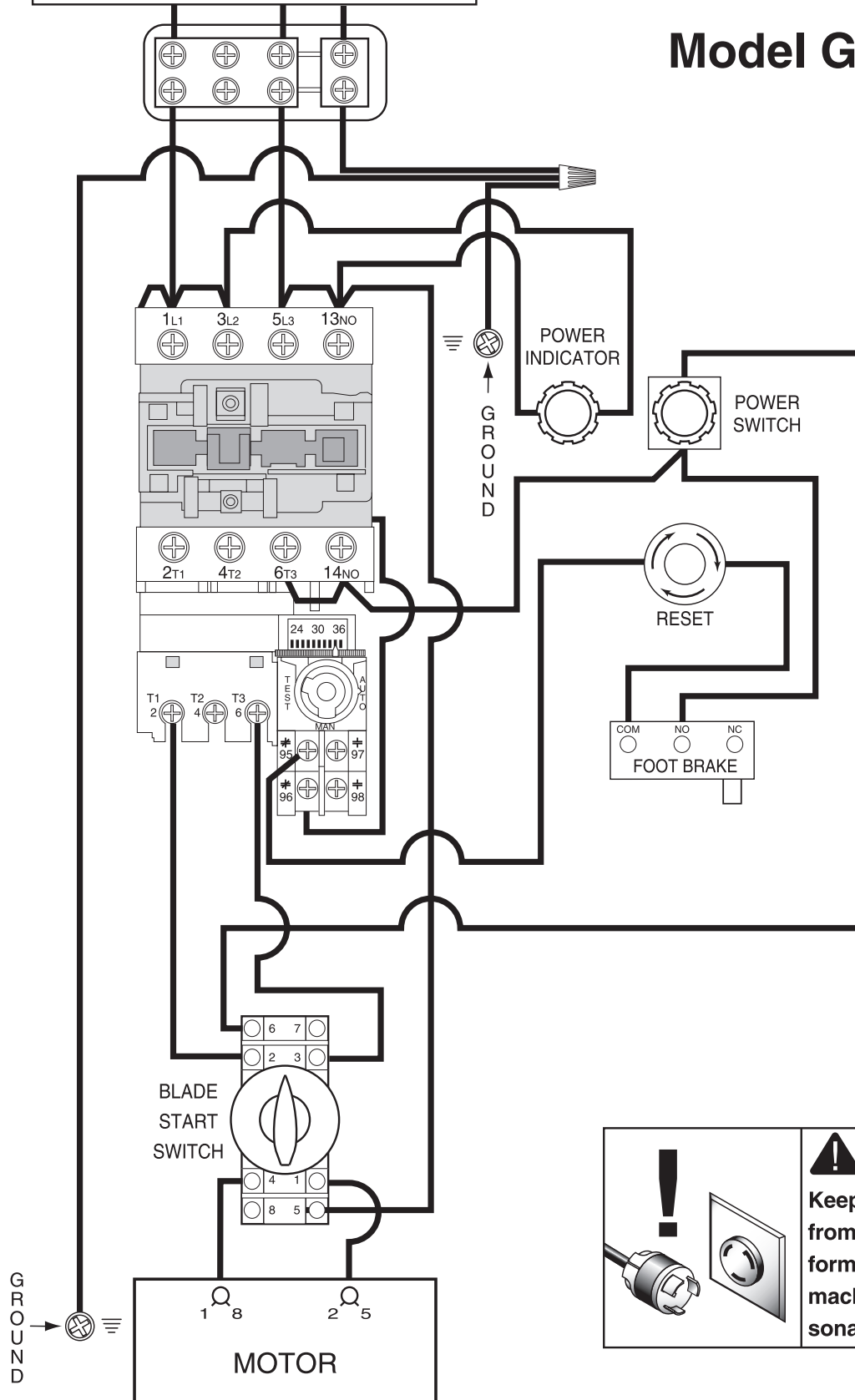
THREE-PHASE  
220 VOLT POWER SOURCE

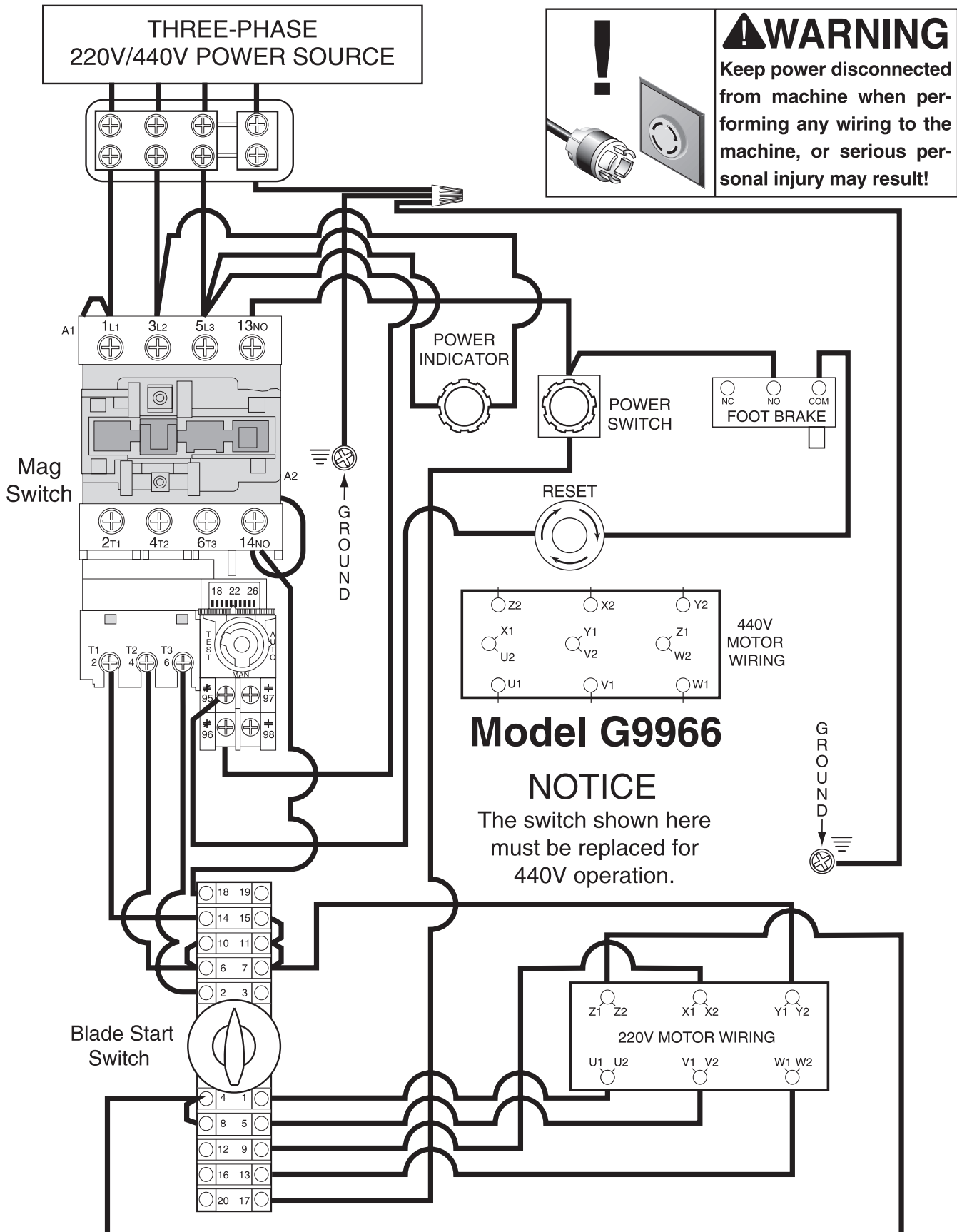
## Model G3620



SINGLE-PHASE  
220 VOLT POWER SOURCE

## Model G9963





# SECTION 8: CLOSURE

The following pages contain general machine data, parts diagrams/lists, troubleshooting guide and Warranty/Return information for your 24" and 27" Resaw Bandsaws.

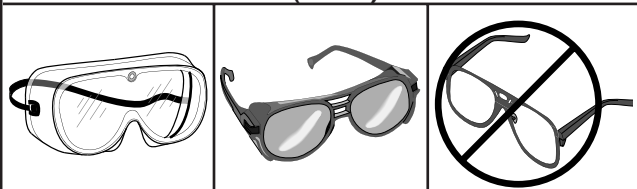
If you need parts or help in assembling your machine, or if you need operational information, we encourage you to call our Service Department. Our trained service technicians will be glad to help you.

If you have comments dealing specifically with this manual, please write to our Bellingham, Washington location using the address in the *General Information* section. The specifications, drawings, and photographs illustrated in this manual represent the 24" and 27" Resaw Bandsaws as supplied when the manual was prepared. However, due to Grizzly's policy of continuous improvement, changes may be made at any time with no obligation on the part of Grizzly.

We have included some important safety measures that are essential to the operation of this machine. While most safety measures are generally universal, Grizzly reminds you that each workshop is different and safety rules should be considered *as they apply to your specific situation*.

## WARNING

Operating this equipment has the potential for flying debris to cause eye injury. Always wear safety glasses or goggles when operating equipment. Everyday glasses or reading glasses only have impact resistant lenses, they are not safety glasses. Be certain the safety glasses you wear meet the appropriate standards of the American National Standards Institute (ANSI).



We recommend you keep a copy of our current catalog for complete information regarding Grizzly's warranty and return policy. If you need additional technical information relating to your machine, or if you need general assistance or replacement parts, please contact the Service Department listed in the *General Information* section.

Additional information sources are necessary to realize the full potential of your machine. Trade journals, woodworking magazines, and your local library are good places to start.

## WARNING

Like all power tools, there is danger associated with the 24" and 27" Resaw Bandsaws. Use your bandsaw with respect and caution to lessen the possibility of mechanical damage or operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

## WARNING

The 24" and 27" Resaw Bandsaws were specifically designed for wood cutting operations. **DO NOT MODIFY AND/OR USE THESE BANDSAWS FOR ANY OTHER PURPOSE.** Modifications or improper use will void the warranty. If you are confused about any aspect of your machine, **DO NOT** use it until all your questions are answered. Serious personal injury may occur.



# MACHINE DATA SHEET

Customer Service #: (570) 546-9663 • To Order Call: (800) 523-4777 • Fax #: (800) 438-5901

## GRIZZLY MODEL G3619/G3620 24" BANDSAW

Design Type: .....Floor Model

### Overall Dimensions:

Table .....31½" x 23¾"  
Overall Height .....80¾"  
Height From Floor to Table .....34¼"  
Width .....42"  
Depth including Fence .....30½"  
Shipping Weight .....990 lbs.  
Net Weight .....748 lbs.  
Crate Size .....84¾" L x 24⅝" W x 43" H  
Footprint .....34½" x 15¾"

### Cutting Capacity:

Left of Blade .....22⅞"  
Height Capacity (Overall) .....13¾"  
Height Capacity (at Blade) .....20½"  
Table Tilt .....45° R

### Construction:

Table .....Precision Ground Cast Iron  
Wheels .....Fully balanced Cast Iron with Rubber Tires  
Rip Fence .....Cast Iron  
Wheel Covers .....Pre-Formed Steel  
Guides .....Roller Guides

### Model G3619 Motor:

Type.....TEFC Capacitor Start Induction  
Horsepower .....5 HP  
Phase / Cycle.....Single-Phase / 60 Hz  
Voltage .....220V  
Amps .....24A  
RPM.....3500  
Bearings.....Shielded & Lubricated Ball Bearings  
Switch .....Magnetic with Thermal Overload Protector

### Model G3620 Motor:

Type.....TEFC Capacitor Start Induction  
Horsepower .....7½ HP  
Phase / Cycle .....Three-Phase / 60 Hz  
Voltage.....220V / 440V  
Amps .....20A / 10A  
RPM.....3500  
Bearings.....Shielded & Lubricated Ball Bearings  
Switch .....Magnetic with Thermal Overload Protector

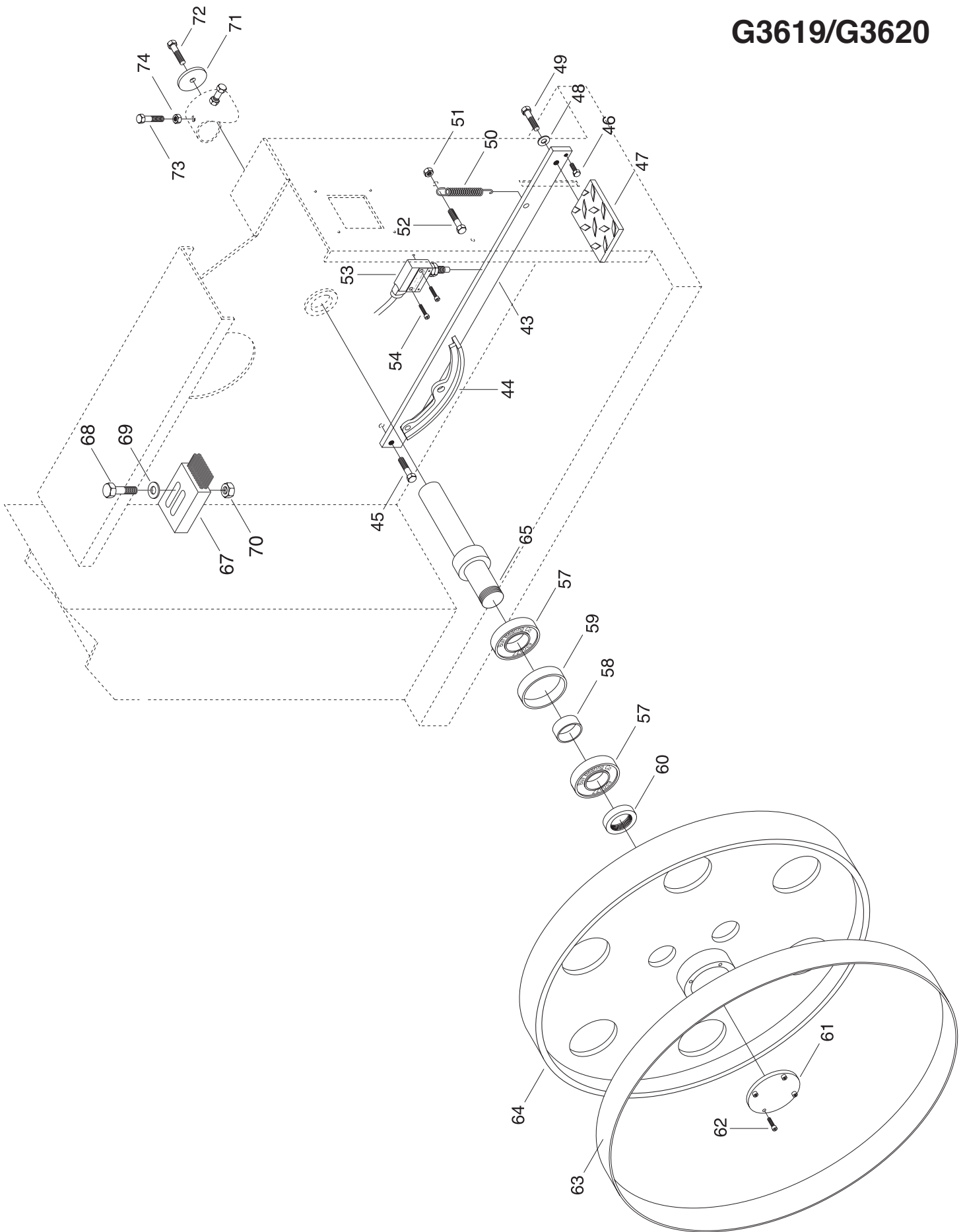
### Blades:

Size Range .....½" - 2"  
Standard Blade Length .....176½" - 173⅝"  
Blade Speeds .....5200 FPM

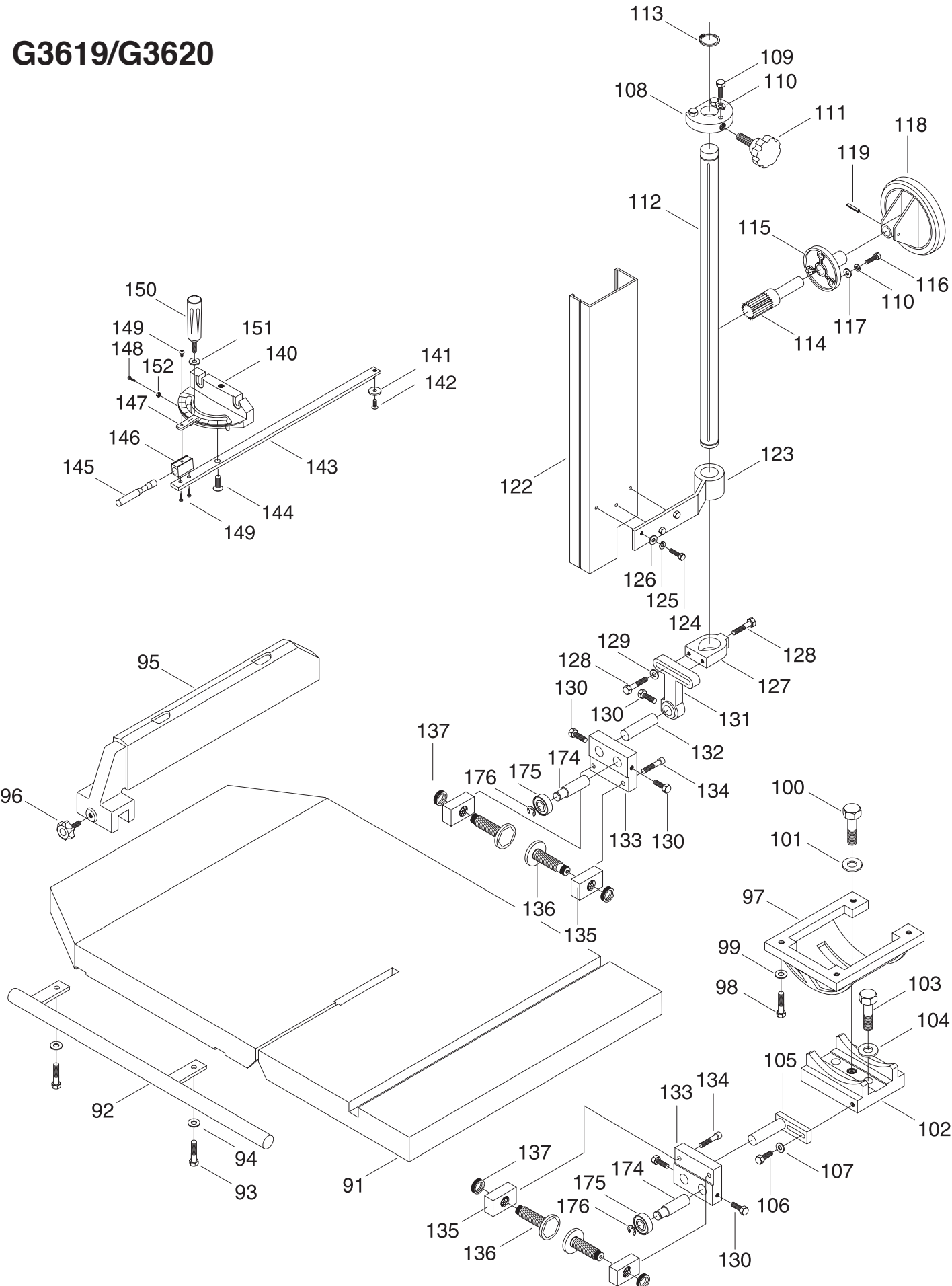
*Specifications, while accurate, are not guaranteed.*



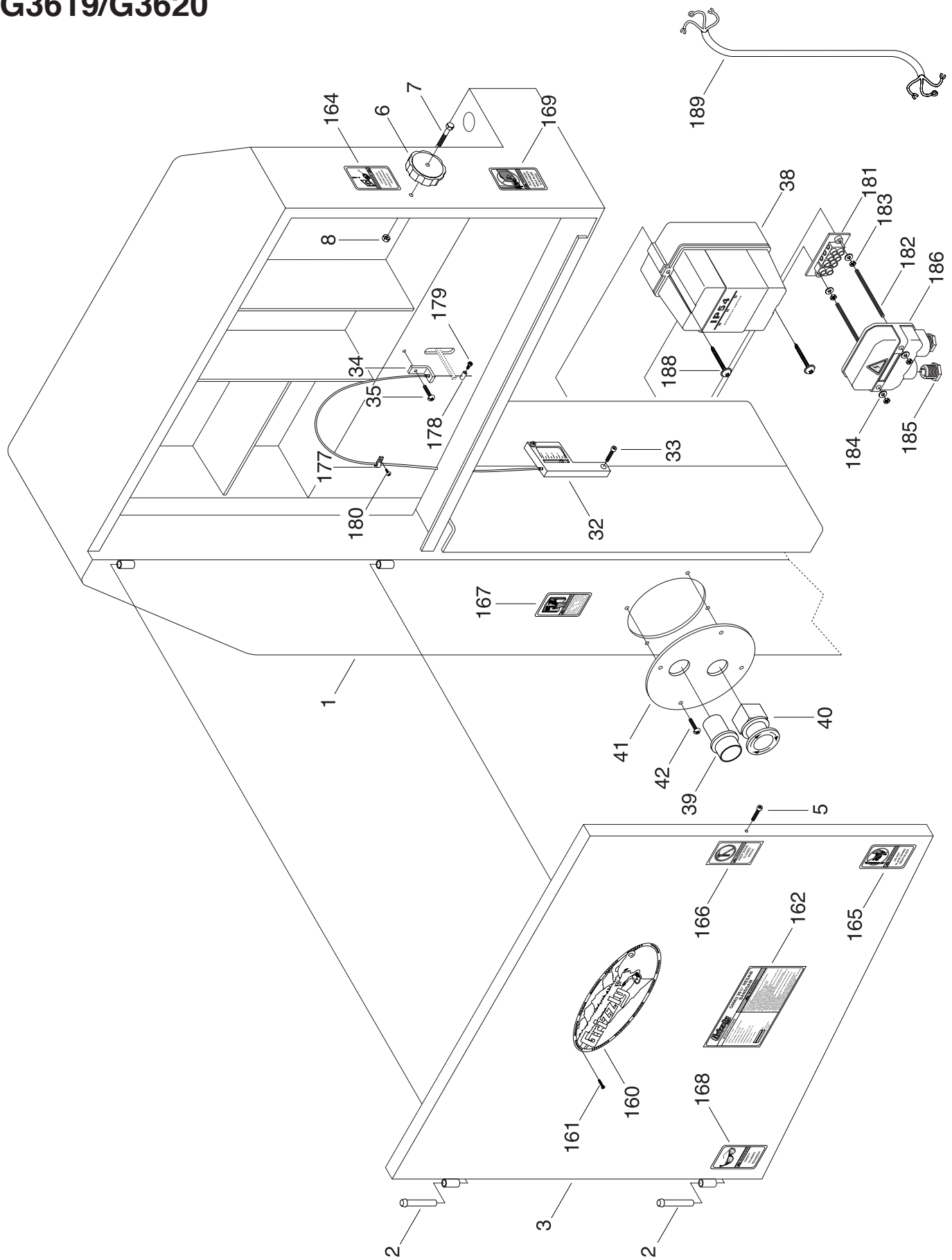




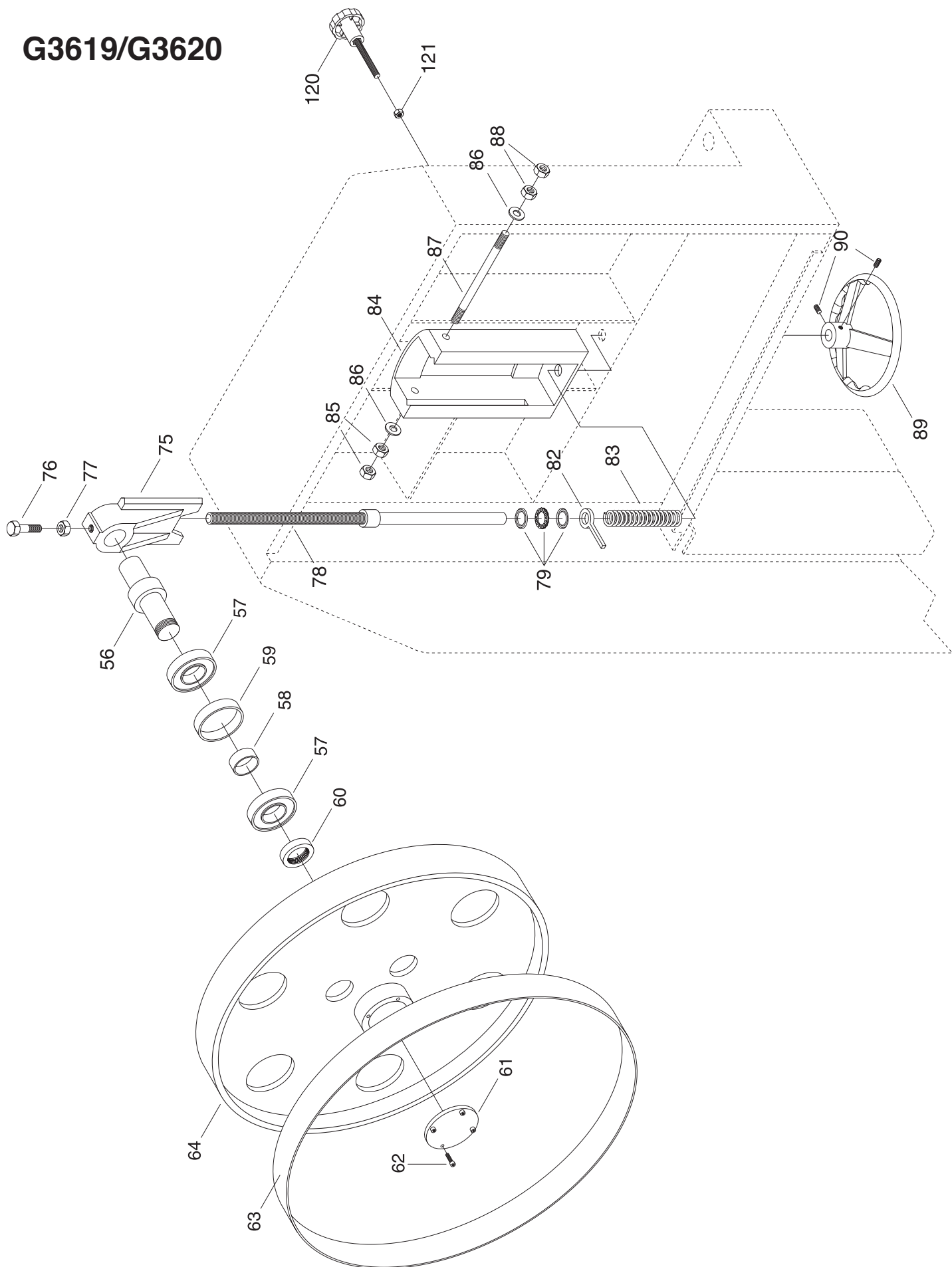
G3619/G3620



# G3619/G3620



G3619/G3620



# G3619/G3620

REF	PART #	DESCRIPTION
001	P3619001	FRAME
002	P3619002	HINGE
003	P3619003	UPPER WHEEL GUARD
004	P3619004	LOWER WHEEL GUARD
005	PSB17	CAP SCREW 1/4"-20 X 3/8"
006	P3619006	WHEEL GUARD LOCK KNOB
007	PSB05	CAP SCREW 1/4"-20 X 3/4"
008	PN05	HEX NUT 1/4"
009	P3619009	1-PH 5 HP MOTOR (G3619)
09-1	P3619009-1	CAPACITOR 300MFD-250V
009	P3620009	3-PH 7.5 HP MOTOR (G3620)
09-2	P3619009-2	CAPACITOR 20MFD-250V
010	PK43M	KEY 8 X 8 X 45
011	P3619011	MOTOR PULLEY
012	PSS08	SETSCREW 5/16"-18 X 1 1/2"
013	P3619013	MOTOR BASE
014	PB24	HEX BOLT 3/8"-16 X 1 1/4"
015	PN08	HEX NUT 3/8"-16
016	PB24	HEX BOLT 3/8"-16 X 1 1/4"
017	PW02	FLAT WASHER 3/8"
018	PLW04	LOCK WASHER 3/8"
019	PN08	HEX NUT 3/8"-16
020	PB60	HEX BOLT 3/8"-16 X 3"
021	PN08	HEX NUT 3/8"-16
022	P3619022	MOTOR BASE SHAFT
023	PVA46	V-BELT A46
024	P3619024	DUST BOARD
025	P3619025	WOOD BOARD
026	PB03	HEX BOLT 5/16"-18 X 1"
027	PW07	FLAT WASHER 5/16"
028	PN02	HEX NUT 5/16"
029	PS06	HEX BOLT 10-20 X 3/8"
030	P3619030	CHIP CHUTE
031	PS06	PHLP HD SCR 10-20 X 3/8"
032	P3619032	BLADE TENSION INDICATOR
033	PSB04	CAP SCREW 1/4"-20 X 1/2"
034	P3619034	WIRE BRACKET
035	PS06	PHLP HD SCR 10-20 X 3/8"
036	PB58	HEX BOLT 3/8"-16 X 2"
037	PN08	HEX NUT 3/8"-16
038	P3619038	1-PH MAG SWITCH (G3619)
38-1	P3619038-1	CONTACTOR/THERMAL OVRLD
038	P3620038	3-PH MAG SWITCH (G3620)
38-1	P3620038-1	CONTACTOR/THERMAL OVRLD
039	P3619039	ON SWITCH (GREEN)
040	P3619040	OFF SWITCH (RED)
041	P3619041	POWER CONTROL PANEL
042	PS06	PHLP HD SCR 10-20 X 3/8"

REF	PART #	DESCRIPTION
043	P3619043	CONNECTION PLATE
044	P3619044	BRAKE LINING
045	PB18	HEX BOLT 3/8"-16 X 1"
046	PB19	HEX BOLT 1/4"-20 X 1/2"
047	P3619047	FOOT BRAKE PEDAL
048	PLW04	LOCK WASHER 3/8"
049	PN08	HEX NUT 3/8"-16
050	P3619050	SPRING
051	PN08	HEX NUT 3/8"-16
052	PB21	HEX BOLT 3/8"-16 X 3/4"
053	P3619053	STOP SWITCH
054	PSB21M	CAP SCREW M4-.7 X 30
055	P3619055	UPPER WHEEL
056	P3619056	UPPER WHEEL SHAFT
057	P6306	BEARING 6306Z
058	P3619058	IN BUSHING
059	P3619059	OUT BUSHING
060	P3619060	SHAFT NUT 1 1/4"
061	P3619061	BEARING COVER
062	PSB05	CAP SCREW 1/4"-20 X 3/4"
063	P3619063	RUBBER CROWN
064	P3619064	LOWER WHEEL
065	P3619065	LOWER WHEEL SHAFT
067	P3619067	BRUSH
068	PB03	HEX BOLT 5/16"-18 X 1"
069	PW07	FLAT WASHER 5/16"
070	PN02	HEX NUT 5/16"
071	P3619071	SPECIAL WASHER 3/8"~2"
072	PB21	HEX BOLT 3/8"-16 X 3/4"
073	PB24	HEX BOLT 3/8"-16 X 1 1/4"
074	PN08	HEX NUT 3/8"-16
075	P3619075	ARBOR BRACKET
076	PB42	HEX BOLT 1/2"-12 X 2"
077	PN13	HEX NUT 1/2"-12
078	P3619078	BLADE TENSION SHAFT
079	P51104	THRUST BEARING 51104
080	P51104	THRUST BEARING 51104
081	P51104	THRUST BEARING 51104
082	P3619082	INDICATOR WIRE PULLER
083	P3619083	SPRING
084	P3619084	BRACKET HOLDER
085	PN13	HEX NUT 1/2"-12
086	PW01	FLAT WASHER 1/2"
087	P3619087	BRACKET SHAFT
088	PN13	HEX NUT 1/2"
089	P3619089	TENSION HANDWHEEL
090	PSS08	SETSCREW 5/16"-18 X 1 1/2"
091	P3619091	TABLE



# G3619/G3620

REF	PART #	DESCRIPTION
092	P3619092	FENCE RAIL
093	PB18	HEX BOLT $\frac{3}{8}$ "-16 X 1"
094	PW02	FLAT WASHER $\frac{3}{8}$ "
095	P3619095	FENCE
096	P3619096	FENCE KNOB $\frac{3}{8}$ "-16 X 1 $\frac{1}{4}$ "
097	P3619097	TRUNNION
098	PSB19	CAP SCREW $\frac{3}{8}$ "-16 X 1 $\frac{1}{4}$ "
099	PLW04	LOCK WASHER $\frac{3}{8}$ "
100	PB67	HEX BOLT $\frac{5}{8}$ "-16 X 2"
101	PW14	FLAT WASHER $\frac{5}{8}$ "
102	P3619102	TRUNNION BRACKET
103	PB42	HEX BOLT $\frac{1}{2}$ "-12 X 2"
104	PLW07	LOCK WASHER $\frac{1}{2}$ "
105	P3619105	BLADE GUIDE FORK
106	PB21	HEX BOLT $\frac{3}{8}$ "-16 X $\frac{3}{4}$ "
107	PW02	FLAT WASHER $\frac{3}{8}$ "
108	P3619108	SHAFT CUP
109	PB03	HEX BOLT $\frac{5}{16}$ "-18 X 1"
110	PLW01	LOCK WASHER $\frac{5}{16}$ "
111	P3619111	LOCK KNOB $\frac{3}{8}$ "-16 X 2 $\frac{1}{4}$ "
112	P3619112	GUIDE SHAFT
113	P3619113	C-CLIP R30
114	P3619114	ELEVATION GEAR SHAFT
115	P3619115	GEAR SHAFT BASE
116	PB07	HEX BOLT $\frac{5}{16}$ "-18 X $\frac{3}{4}$ "
117	PLW01	LOCK WASHER $\frac{5}{16}$ "
118	P3619118	HANDWHEEL
119	P3619119	SPRING KEY M4
120	P3619120	TRACK KNOB $\frac{1}{2}$ "-12 X 2 $\frac{1}{2}$ "
121	PN06	HEX NUT $\frac{1}{2}$ "-20
122	P3619122	BLADE GUIDE GUARD
123	P3619123	BLADE GUARD BRACKET
124	PB19	HEX BOLT $\frac{1}{4}$ "-20 X $\frac{1}{2}$ "
125	PLW02	LOCK WASHER $\frac{1}{4}$ "
126	PW06	FLAT WASHER $\frac{1}{4}$ "
127	P3619127	BLADE GUIDE HOLDER
128	PB03	HEX BOLT $\frac{5}{16}$ "-18 X 1"
129	PW07	FLAT WASHER $\frac{5}{16}$ "
130	PB07	HEX BOLT $\frac{5}{16}$ "-18 X $\frac{3}{4}$ "
131	P3619131	ADJUSTMENT BRACKET
132	P3619132	BRACKET ARBOR
133	P3619133	BLADE GUIDE BASE
134	PSB14M	CAP SCREW M8-1 X 20
135	P3619135	GUIDE WHEEL BRACKET

REF	PART #	DESCRIPTION
136	P3619136	GUIDE WHEEL
137	P3619137	GUIDE WHEEL NUT $\frac{3}{4}$ "
139	P3619139	SLIDING BASE
140A	P3619140A	COMPLETE MITER GAUGE
140	P3619200	MITER GAUGE BODY
141	P3619201	T-SLOT WASHER
142	PFH09	FLAT HD SCR $\frac{1}{4}$ "-20 X $\frac{5}{16}$ "
143	P3619203	MITER BAR
144	P3619204	SPECIAL BOLT $\frac{1}{4}$ "-20 X $\frac{7}{16}$ "
145	P3619205	STOP PIN
146	P3619206	BLOCK
147	P3619207	INDICATOR
148	PS29	PHLP HD SCR 6-32 X $\frac{5}{8}$ "
149	PS06	PHLP HD SCR 10-24 X $\frac{3}{8}$ "
150	P3619210	HANDLE $\frac{5}{16}$ "-18 X 1 $\frac{1}{2}$ "
151	PW07	FLAT WASHER $\frac{5}{16}$ "
152	PN12	HEX NUT 6-32
160	G8589	LARGE GRIZZLY LOGO
161	PHTEK10	SELF TAP SCR #4 X $\frac{3}{8}$ "
162	P36190162	G3619 ID LABEL
162	P36200162	G3620 ID LABEL
163	PLABEL-14	ELECTRICITY LABEL
164	PLABEL-18	UNPLUG BANDSAW LABEL
165	PLABEL-19	HANDS/BLADE LABEL
166	PLABEL-20	DON'T OPEN LABEL
167	PLABEL-12	READ MANUAL LABEL
168	PLABEL-11	SAFETY GLASSES LABEL
169	PLABEL-21	MOVING/ADJUST LABEL
174	P3619174	THRUST BEARING SHAFT
175	P6202RS	THRUST BEARING 6202-3
176	PEC05M	E-CLIP 15MM
177	P3619177	CABLE CLIP
178	P3619178	CABLE NUT 6-32
179	PS37	PHLP HD SCR 6-32 X $\frac{5}{16}$ "
180	PS06	PHLP HD SCR 10-24 X $\frac{3}{8}$ "
181	P3619181	TERMINAL BLOCK
182	P3619182	STUD 10-24 X 2 $\frac{1}{2}$ "
183	PN07	HEX NUT 10-24
184	PW03	FLAT WASHER 10-24
185	PSW10	STRAIN RELIEF $\frac{3}{4}$ "
186	P3619186	COVER
188	PHTEK11	SELF TAP SCR 10-24 X 2 $\frac{1}{4}$ "
189	P3619189	POWER CORD (G3619)
189	P3620189	POWER CORD (G3620)



# MACHINE DATA SHEET

Customer Service #: (570) 546-9663 • To Order Call: (800) 523-4777 • Fax #: (800) 438-5901

## GRIZZLY MODEL G9963/G9966 27" BANDSAW

Design Type: ..... Floor Model

### Overall Dimensions:

Table ..... 39 $\frac{1}{4}$ " x 27 $\frac{1}{2}$ "  
Overall Height..... 92"  
Height From Floor to Table ..... 36 $\frac{1}{2}$ "  
Width ..... 52"  
Depth including Fence ..... 36"  
Shipping Weight ..... 1430 lbs.  
Net Weight ..... 1100 lbs.  
Crate Size ..... 45 $\frac{3}{8}$ " H x 29 $\frac{1}{2}$ " W x 99 $\frac{1}{2}$ " L  
Footprint ..... 40" x 18"

### Cutting Capacity:

Left of Blade ..... 26 $\frac{1}{2}$ "  
Height Capacity (Overall) ..... 21 $\frac{1}{2}$ "  
Table Tilt ..... 45° R

### Construction:

Table ..... Precision Ground Cast Iron  
Wheels ..... Fully balanced Cast Iron  
Rip Fence ..... Cast Iron  
Wheel Covers ..... Pre-Formed Steel

### Model P9963 Motor:

Type..... TEFC Capacitor Start Induction  
Horsepower ..... 7 $\frac{1}{2}$  HP  
Phase / Cycle..... Single-Phase / 60 Hz  
Voltage ..... 220V  
Amps ..... 33A  
RPM..... 1725  
Bearings..... Shielded & Lubricated Ball Bearings  
Switch ..... Magnetic with Thermal Overload Protector

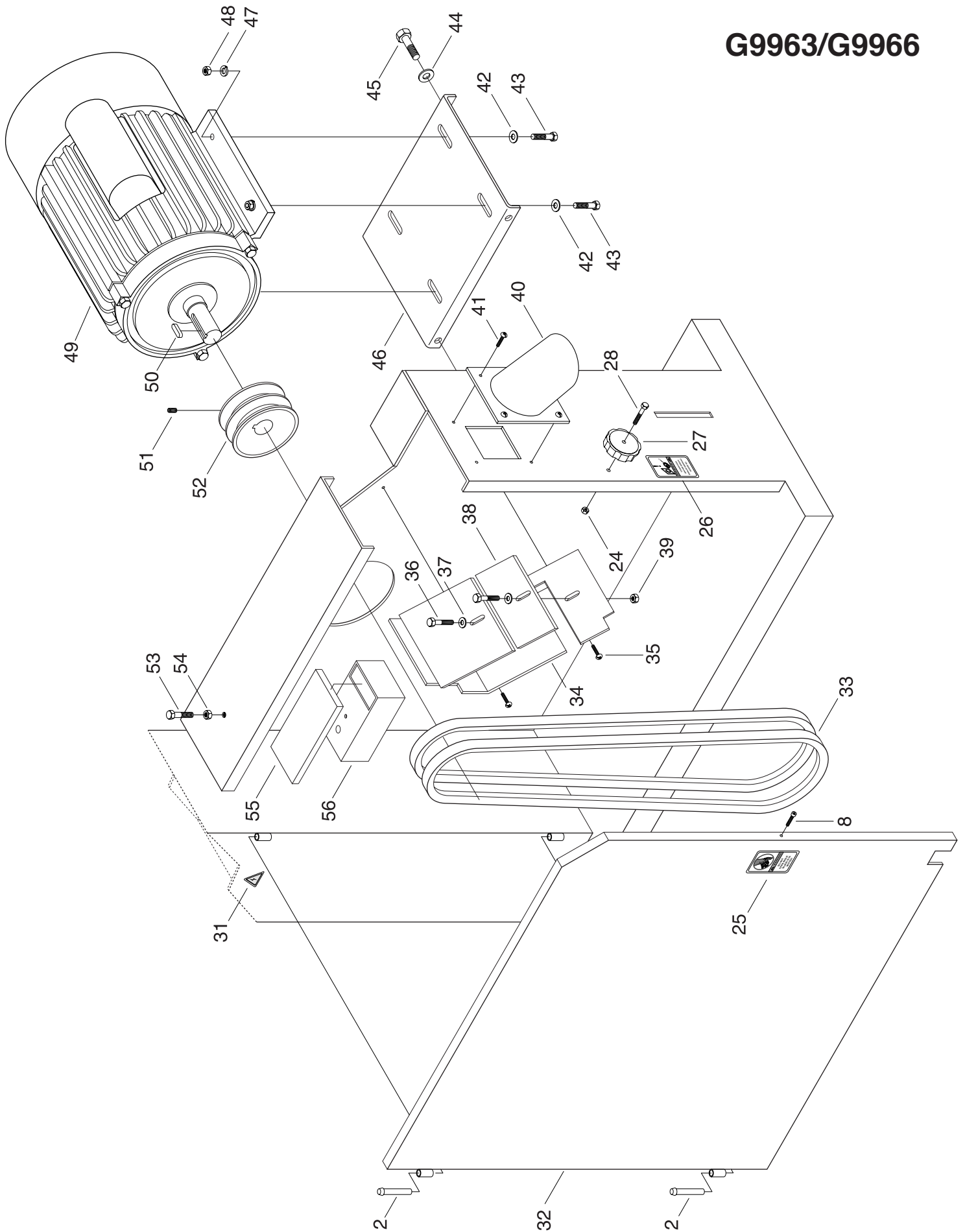
### Model G9966 Motor:

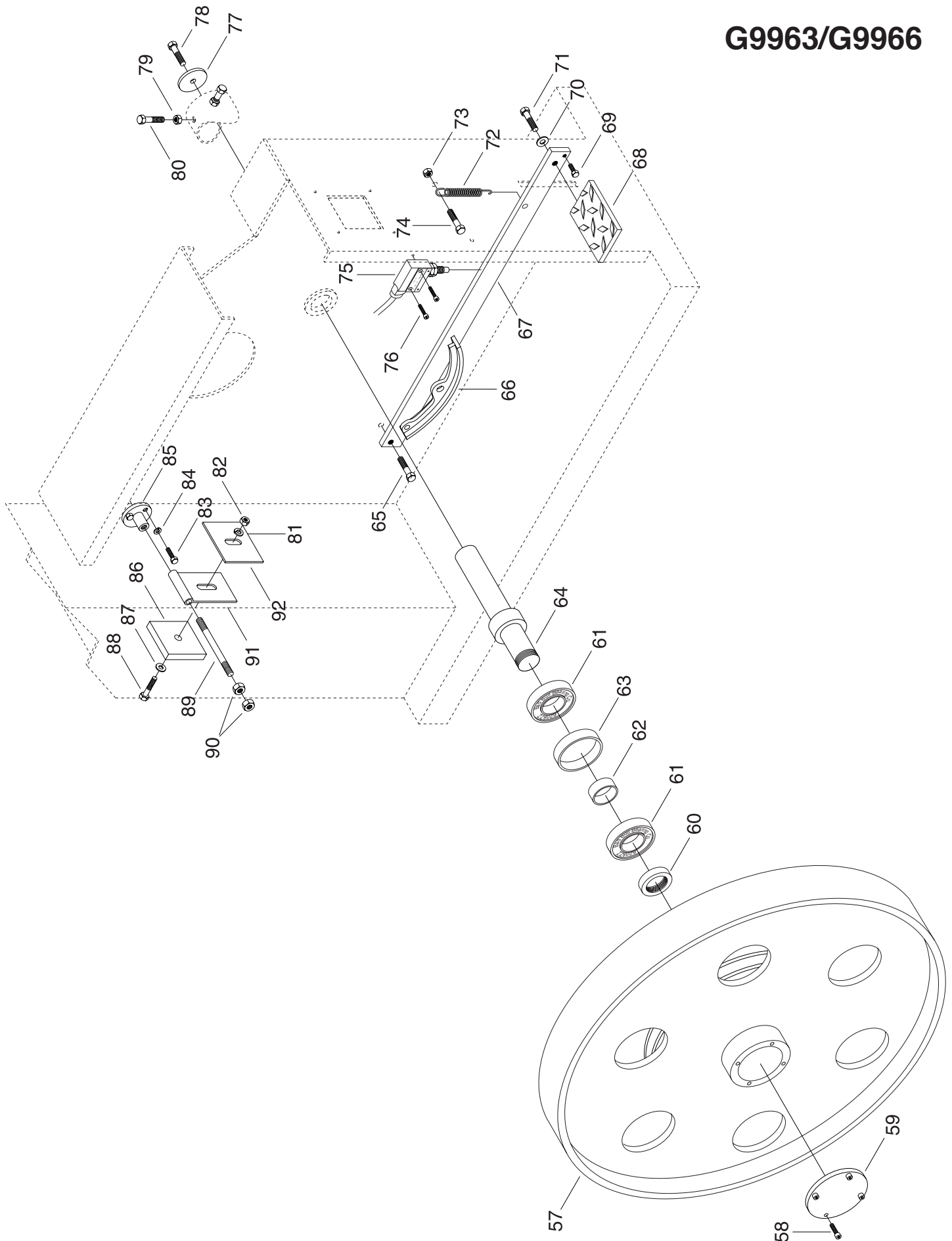
Type..... TEFC Capacitor Start Induction  
Horsepower ..... 7 $\frac{1}{2}$  HP  
Phase / Cycle ..... Three-Phase / 60 Hz  
Voltage..... 220V / 440V  
Amps ..... 22A / 11A  
RPM..... 1725  
Bearings ..... Sealed & Lubricated Ball Bearings  
Switch ..... Magnetic with Thermal Overload Protector

### Blades:

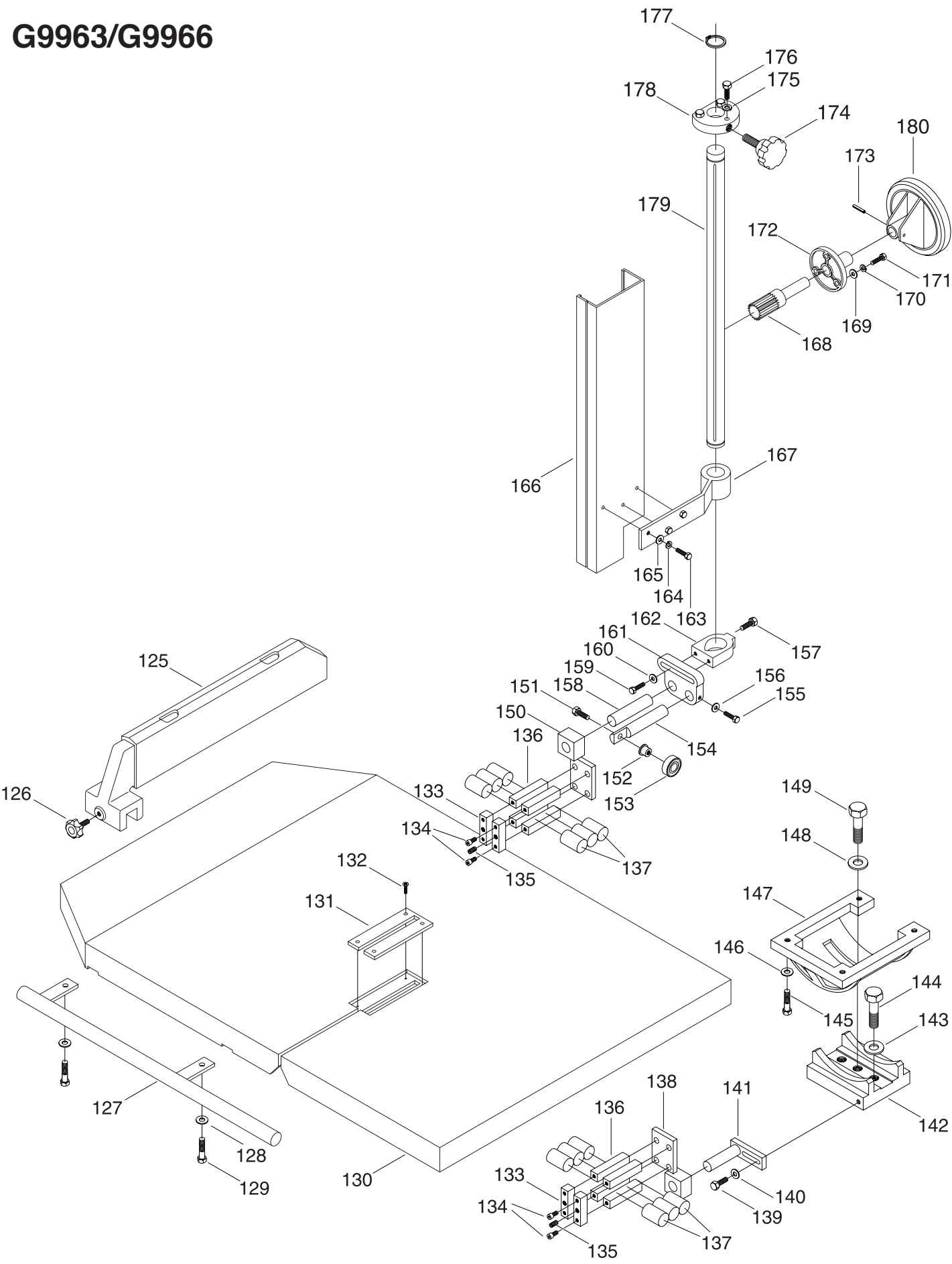
Size Range ..... 1" - 3"  
Standard Blade Length ..... 206 $\frac{1}{4}$ " - 207"  
Blade Speeds ..... 4900 FPM

*Specifications, while accurate, are not guaranteed.*

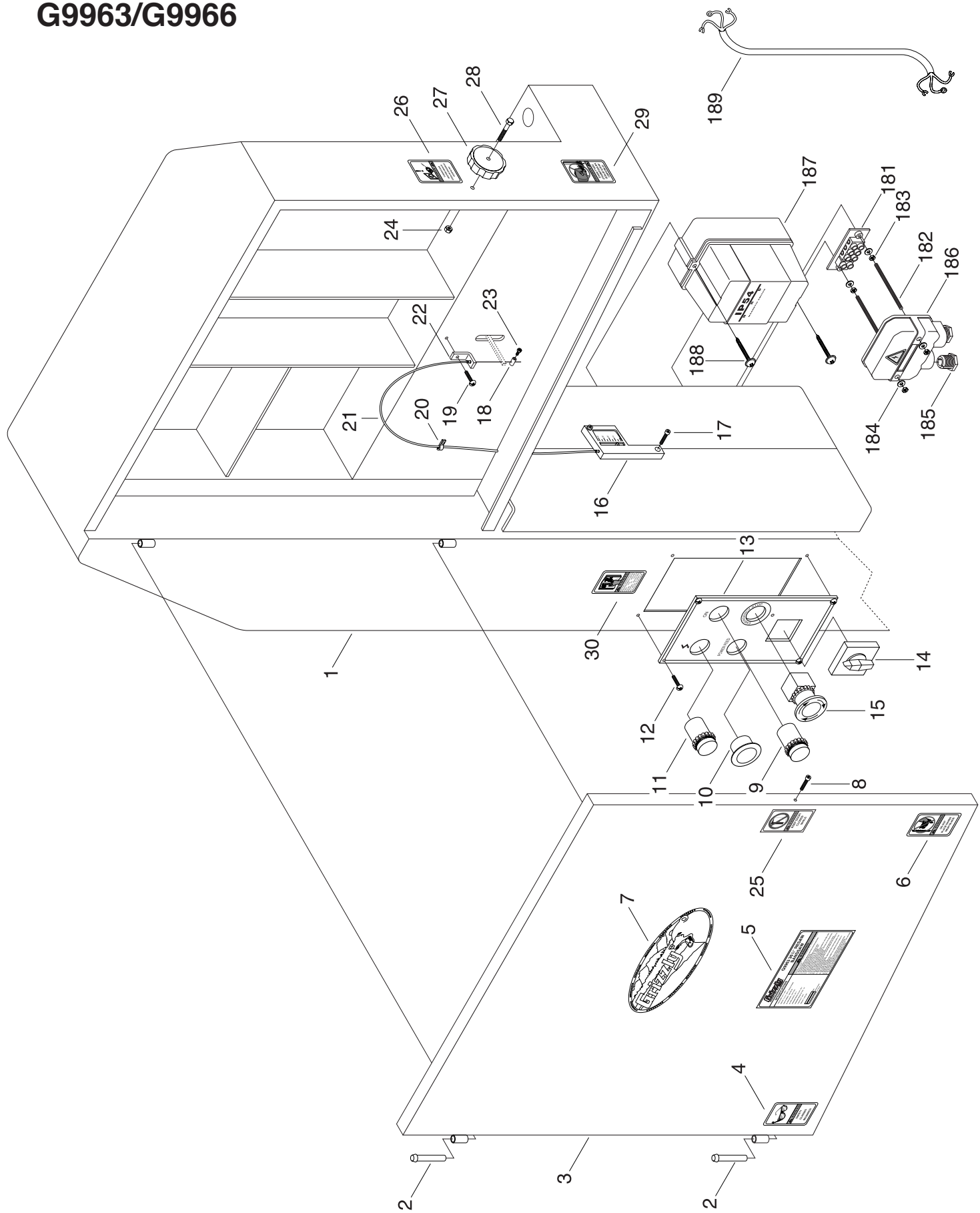




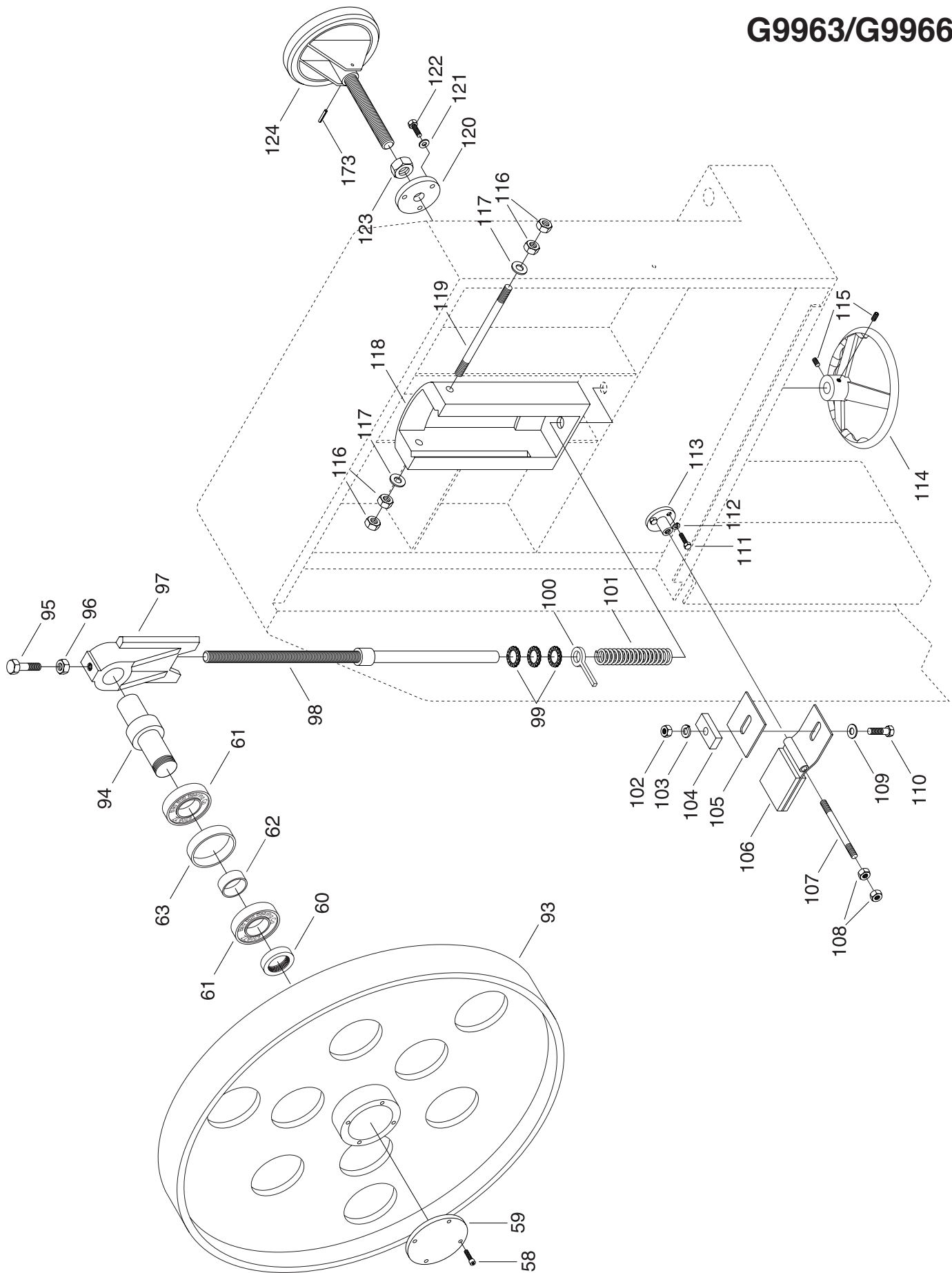
G9963/G9966



G9963/G9966







# G9963/G9966

REF	PART #	DESCRIPTION
01	P9963001	FRAME
02	P9963002	HINGE PIN
03	P9963003	UPPER WHEEL GUARD
04	PLABEL-11	SAFETY GLASSES LABEL
05	P9963005	ID/WARNING LABEL
06	PLABEL-19	HANDS/BLADE LABEL
07	G8589	GRIZZLY NAMEPLATE
08	PSB17	CAP SCREW 1/4"-20 X 3/8"
09	P9963009	ON SWITCH
10	P9963010	HOLE CAP
11	P9963011	RED INDICATOR LIGHT
12	PS06	PHLPS HD SCR 10-24 X 3/8"
13	P9963013	SWITCH PANEL
14	P9963014	BLADE POWER SWITCH
15	P9963015	EMERGENCY STOP SWITCH
16	P9963016	BLADE TENSION INDICATOR
17	PSB41	CAP SCREW 10-24 X 1/2"
18	P9963018	SPECIAL NUT
19	PS06	PHLPS HD SCR 10-24 X 3/8"
20	P9963020	CABLE HANGER
21	P9963021	STOP CABLE
22	P9963022	WIRE BRACKET
23	P9963023	SPECIAL SCREW
24	PN05	HEX NUT 1/4"-20
25	PLABEL-20	DO NOT OPEN LABEL
26	PLABEL-18	UNPLUG BANDSAW LABEL
27	P9963027	WHEEL GUARD LOCK KNOB
28	PSB05	CAP SCREW 1/4"-20 X 3/4"
29	PLABEL-21	MOVING/ADJUST LABEL
30	PLABEL-12	READ MANUAL LABEL
31	PLABEL-14	ELECTRICITY LABEL
32	P9963032	LOWER WHEEL GUARD
33	PVB46	V-BELT B46
34	P9963034	CHIP STOPPER
35	PS06	PHLPS HD SCR 10-24 X 3/8"
36	PB03	HEX BOLT 5/16"-18 X 1"
37	PW07	FLAT WASHER 5/16"
38	P9963038	WOOD BOARD
39	PN02	HEX NUT 5/16"-18
40	P9963040	CHIP CHUTE
41	PS06	PHLPS HD SCR 10-24 X 3/8"
42	PW02	FLAT WASHER 3/8"
43	PB16	HEX BOLT 3/8"-16 X 1 1/2"
44	PW01	FLAT WASHER 1/2"
45	PB40	HEX BOLT 1/2"-12 X 1 1/4"
46	P9963046	MOTOR BASE
47	PLW04	LOCK WASHER 3/8"
48	PN08	HEX NUT 3/8"-16

REF	PART #	DESCRIPTION
49	P9963049	1-PH 7.5 HP MOTOR (G9963)
49	P9966049	3-PH 7.5 HP MOTOR (G9966)
49-1	P9963049-1	CAPACITOR 400MFD-250V
49-2	P9963049-2	CAPACITOR 40MFD-250V
50	P3619050	KEY
51	PSS08	SET SCREW 5/16"-18 X 1/2"
52	P9963052	MOTOR PULLEY
53	PB58	HEX BOLT 3/8"-16 X 2"
54	PN08	HEX NUT 3/8"-16
55	P9963055	LUBRICANT ABSORBER
56	P9963056	LUBRICANT RESERVOIR
57	P9963057	LOWER WHEEL
58	PSB05	CAP SCREW 1/4"-20 X 3/4"
59	P9963059	BEARING COVER
60	P9963060	SHAFT NUT
61	P6208ZZ	BALL BEARING 6208ZZ
62	P9963062	INNER BUSHING
63	P9963063	OUTER BUSHING
64	P9963064	LOWER WHEEL ARBOR
65	PN08	HEX BOLT 3/8"-16
66	P9963066	BRAKE LINING
67	P9963067	CONNECTION PLATE
68	P9963068	FOOT BRAKE PEDAL
69	PB19	HEX BOLT 1/4"-20 X 1/2"
70	PW02	FLAT WASHER 3/8"
71	PB21	HEX BOLT 3/8"-16 X 3/4"
72	P9963072	SPRING
73	PN08	HEX NUT 3/8"-16
74	PB21	HEX BOLT
75	P9963075	STOP SWITCH
76	PSB21M	CAP SCREW M4 X P0.7 X 30
77	P9963077	SPECIAL WASHER
78	PB16	HEX BOLT 3/8"-16 X 1 1/2"
79	PN08	HEX NUT 3/8"-16
80	PB18	HEX BOLT 3/8"-16 X 1"
81	PLW01	LOCK WASHER 1/4"
82	PN02	HEX NUT 5/16"-18
83	PB02	HEX BOLT 1/4"-20 X 5/8"
84	PLW02	LOCK WASHER 1/4"
85	P9963085	LOWER ARBOR BRACKET
86	P9963086	CLEANER WEIGHT
87	PW07	FLAT WASHER 5/16"
88	PB03	HEX BOLT 5/16"-18 X 1"
89	P9963089	CLEANER SHAFT
90	PNO2M	HEX NUT M10 X P1.5
91	P9963091	LOWER CLEANER BRACKET
92	P9963092	BRONZE CLEANER
93	P9963093	UPPER WHEEL

# G9963/G9966

REF	PART #	DESCRIPTION
94	P9963094	UPPER WHEEL SHAFT
95	PB42	HEX BOLT 1/2"-12 X 2"
96	PN13	HEX NUT 1/2"-12
97	P9963097	ARBOR BRACKET
98	P9963098	BLADE TENSION SHAFT
99	P51104	SUPPORT BEARING 51104
100	P9963100	INDICATOR WIRE PULLER
101	P9963101	SPRING
102	PN02	HEX NUT 5/16"-18
103	PLW01	LOCK WASHER 5/16"
104	P9963104	PRESSURE PLATE
105	P9963105	BRONZE CLEANER
106	P9963106	COUNTERBALANCE
107	P9963107	CLEANER SHAFT
108	PN02M	HEX NUT M10-P1.5
109	PW07	FLAT WASHER 5/16"
110	PB03	HEX BOLT 5/16"-18 X 1"
111	PB02	HEX BOLT 1/4"-20 X 5/8"
112	PLW02	LOCK WASHER 1/4"
113	P9963113	UPPER ARBOR BRACKET
114	P9963114	TENSION HANDWHEEL
115	PSS08	SET SCREW 5/16"-18 X 1/2"
116	PN01	HEX NUT 1/2"-12
117	PW01	FLAT WASHER 1/2"
118	P9963118	ARBOR BRACKET HOLDER
119	P9963119	PIVOT SHAFT
120	P9963120	HANDWHEEL BRACKET
121	PW07	FLAT WASHER 5/16"
122	PB03	HEX BOLT 5/16"-18 X 1"
123	PN17	HEX NUT 3/4"-10
124	P9963124	TRACKING HANDWHEEL
125	P9963125	FENCE
126	P9963126	FENCE LOCK KNOB
127	P9963127	FENCE RAIL
128	PW02	FLAT WASHER 3/8"
129	PB18	HEX BOLT 3/8"-16 X 1"
130	P9963130	TABLE
131	P9963131	TABLE INSERT
132	PS01	PHLPS HD SCR 10-24 X 1/2"
133	P9963133	CLAMPING PIECE
134	PSB01	CAP SCREW 1/4"-20 X 5/8"
135	PSS18	SET SCREW 5/16"-18 X 3/4"
136	P9963136	BLADE GUIDE HOLDER
137	P9963137	BLADE GUIDE
138	P9963138	BLADE GUIDE BASE
139	PB03	HEX BOLT 5/16"-18 X 1"
140	PW07	FLAT WASHER 5/16"
141	P9963141	BLADE GUIDE SUPPORT
142	P9963142	TRUNNION BRACKET
143	PW14	FLAT WASHER 5/8"

REF	PART #	DESCRIPTION
144	PB67	HEX BOLT 5/8"-11 X 2"
145	PB24	HEX BOLT 3/8"-16 X 1 1/4"
146	PW02	FLAT WASHER 3/8"
147	P9963147	TRUNNION
148	PW14	FLAT WASHER 5/8"
149	PB68	HEX BOLT 5/8"-11 X 2
150	P9963150	BLADE GUIDE BASE
151	PB21	HEX BOLT 3/8"-16 X 3/4"
152	P9963152	BUSHING
153	P6202	BALL BEARING 6202ZZ
154	P9963154	BEARING BRACKET ARBOR
155	PB07	HEX BOLT 5/16"-18 X 3/4"
156	PW07	FLAT WASHER 5/16"
157	PB03	HEX BOLT 5/16"-18 X 1"
158	P9963158	BLADE GUIDE SHAFT
159	PB03	HEX BOLT 5/16"-18 X 1"
160	PW07	FLAT WASHER 5/16"
161	P9963161	GUIDE ADJUST BRACKET
162	P9963162	BLADE GUIDE SUPPORT
163	PB19	HEX BOLT 1/4"-20 X 1/2"
164	PLW02	LOCK WASHER 1/4"
165	PW06	FLAT WASHER 1/4"
166	P9963166	BLADE GUARD
167	P9963167	BLADE GUARD BRACKET
168	P9963168	GEAR SHAFT
169	PW07	FLAT WASHER 5/16"
170	PLW01	LOCK WASHER 5/16"
171	PB03	HEX BOLT 5/16"-18 X 1"
172	P9963172	GEAR SHAFT BASE
173	PRP51M	ROLL PIN 4 X 40
174	P9963174	BLADE GUIDE LOCK KNOB
175	PLW01	LOCK WASHER 5/16"
176	PB03	HEX BOLT 5/16"-18 X 1"
177	PR19M	C-CLIP
178	P9963178	SHAFT CAP
179	P9963179	GUIDE SHAFT
180	P9962180	GUIDE POST HANDWHEEL
181	P9963181	TERMINAL BLOCK
182	P9963182	STUD 10-24 X 2 1/2"
183	PN07	HEX NUT 10-24
184	PW03	FLAT WASHER 10-24
185	P9963185	STRAIN RELIEF
186	P9963186	COVER
187	P9963187	MAGNETIC SWITCH (G9963)
187-1	P9963187-1	CONTACTOR/THERM OVRLD
187	P9966187	MAGNETIC SWITCH (G9966)
187-1	P9966187-1	CONTACTOR/THERM OVRLD
188	PHTEK5	SELF TAP SCR 10-24 X 2 1/4"
189	P9963189	POWER CORD (G9963)
189	P9966189	POWER CORD (G9966)

# TROUBLESHOOTING

Motor will not start.	<ol style="list-style-type: none"> <li>1. Low voltage.</li> <li>2. Open circuit in motor or loose connections.</li> </ol>	<ol style="list-style-type: none"> <li>1. Check power line for proper voltage.</li> <li>2. Inspect all lead connections on motor for loose or open connections.</li> </ol>
Motor will not start; fuses or circuit breakers blow.	<ol style="list-style-type: none"> <li>1. Short circuit in line cord or plug.</li> <li>2. Short circuit in motor or loose connections.</li> <li>3. Circuit Overloaded</li> </ol>	<ol style="list-style-type: none"> <li>1. Inspect cord or plug for damaged insulation and shorted wires.</li> <li>2. Inspect all connections on motor for loose or shorted terminals or worn insulation.</li> <li>3. Reduce load on circuit.</li> </ol>
Motor fails to develop full power (power output of motor decreases rapidly with decrease in voltage at motor terminals).	<ol style="list-style-type: none"> <li>1. Power line overloaded with lights, appliances, and other motors.</li> <li>2. Undersized wires or circuits too long.</li> <li>3. General overloading of power company facilities.</li> </ol>	<ol style="list-style-type: none"> <li>1. Reduce load on power line.</li> <li>2. Increase wire sizes or reduce length of wire.</li> <li>3. Request a power check from the power company.</li> </ol>
Motor overheats.	<ol style="list-style-type: none"> <li>1. Motor overloaded.</li> <li>2. Air circulation through the motor restricted.</li> </ol>	<ol style="list-style-type: none"> <li>1. Reduce load on motor.</li> <li>2. Clean out motor to provide normal air circulation.</li> </ol>
Motor stalls (resulting in blown fuses or tripped circuit).	<ol style="list-style-type: none"> <li>1. Short circuit in motor or loose connections.</li> <li>2. Low voltage.</li> <li>3. Incorrect fuses or circuit breakers in power line.</li> <li>4. Motor overloaded.</li> </ol>	<ol style="list-style-type: none"> <li>1. Inspect connections on motor for loose or shorted terminals or worn insulation.</li> <li>2. Correct the low voltage conditions.</li> <li>3. Install correct fuses or circuit breakers.</li> <li>4. Reduce load on motor.</li> </ol>
Machine slows when operating.	Applying too much pressure to workpiece.	Feed workpiece slower.
Blade does not run evenly on wheels or runs off.	<ol style="list-style-type: none"> <li>1. Tracking is not adjusted properly.</li> <li>2. Wheels are not coplanar.</li> </ol>	<ol style="list-style-type: none"> <li>1. Adjust tracking.</li> <li>2. Adjust wheel alignment.</li> </ol>
Blade does not cut evenly.	<ol style="list-style-type: none"> <li>1. Blade is not properly tensioned.</li> <li>2. Wheels are not coplanar.</li> <li>3. Tooth set is uneven.</li> <li>4. Teeth are sharper on one side than the other.</li> </ol>	<ol style="list-style-type: none"> <li>1. Adjust blade tension.</li> <li>2. Adjust wheel alignment.</li> <li>3. Skew fence to compensate or replace blade.</li> <li>4. Skew fence to compensate or replace blade.</li> </ol>
Blade slows when cutting. Blade makes a squealing noise, especially on start-up.	<ol style="list-style-type: none"> <li>1. V-belt loose.</li> <li>2. V-belt worn out.</li> </ol>	<ol style="list-style-type: none"> <li>1. Tighten V-belt.</li> <li>2. Replace V-belt.</li> </ol>
Ticking sound when the saw is running.	Weld contacting support bearing.	Use the G2516 Stone to smooth and round the back of the blade.
Blade contacting table insert.	<ol style="list-style-type: none"> <li>1. Excessive side pressure when cutting.</li> <li>2. Table improperly adjusted.</li> <li>3. Opening in insert too narrow.</li> </ol>	<ol style="list-style-type: none"> <li>1. Reduce side pressure.</li> <li>2. Adjust table.</li> <li>3. File opening in table insert larger.</li> </ol>
Excessive vibration.	<ol style="list-style-type: none"> <li>1. Rubber pads not installed under stand.</li> <li>2. Wheels not coplanar.</li> <li>3. Wheel rubber incorrectly installed.</li> <li>4. Worn out V-belt.</li> <li>5. Bent or worn out blade.</li> <li>6. Wheels out of balance.</li> </ol>	<ol style="list-style-type: none"> <li>1. Install rubber pads under stand.</li> <li>2. Adjust wheel alignment.</li> <li>3. Re-install wheel rubber crown.</li> <li>4. Replace V-belt.</li> <li>5. Replace blade.</li> <li>6. Replace wheels.</li> </ol>

# WARRANTY AND RETURNS

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Grizzly Industrial, Inc. warrants every product it sells for a period of **1 year** to the original purchaser from the date of purchase. This warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence, accidents, repairs or alterations or lack of maintenance. This is Grizzly's sole written warranty and any and all warranties that may be implied by law, including any merchantability or fitness, for any particular purpose, are hereby limited to the duration of this written warranty. We do not warrant or represent that the merchandise complies with the provisions of any law or acts unless the manufacturer so warrants. In no event shall Grizzly's liability under this warranty exceed the purchase price paid for the product and any legal actions brought against Grizzly shall be tried in the State of Washington, County of Whatcom.

We shall in no event be liable for death, injuries to persons or property or for incidental, contingent, special, or consequential damages arising from the use of our products.

To take advantage of this warranty, contact us by mail or phone and give us all the details. We will then issue you a "Return Number," which must be clearly posted on the outside as well as the inside of the carton. We will not accept any item back without this number. Proof of purchase must accompany the merchandise.

The manufacturers reserve the right to change specifications at any time because they constantly strive to achieve better quality equipment. We make every effort to ensure that our products meet high quality and durability standards and we hope you never need to use this warranty.

Please feel free to write or call us if you have any questions about the machine or the manual.

Thank you again for your business and continued support. We hope to serve you again soon.

# WARRANTY CARD

Name \_\_\_\_\_  
Street \_\_\_\_\_  
City \_\_\_\_\_ State \_\_\_\_\_ Zip \_\_\_\_\_  
Phone Number \_\_\_\_\_ E-Mail \_\_\_\_\_ FAX \_\_\_\_\_  
MODEL \_\_\_\_\_ Serial # \_\_\_\_\_ Order \_\_\_\_\_

The following information is given on a voluntary basis. It will be used for marketing purposes to help us develop better products and services. Of course, all information is strictly confidential.

1. How did you learn about us?  
\_\_\_\_ Advertisement                      \_\_\_\_ Friend  
\_\_\_\_ Catalog                                \_\_\_\_ Card Deck  
\_\_\_\_ World Wide Web  
\_\_\_\_ Other \_\_\_\_\_
2. Which of the following magazines do you subscribe to.  
\_\_\_\_ American Woodworker              \_\_\_\_ Practical Homeowner  
\_\_\_\_ Cabinetmaker                        \_\_\_\_ Shop Notes  
\_\_\_\_ Family Handyman                    \_\_\_\_ Today's Homeowner  
\_\_\_\_ Fine Homebuilding                  \_\_\_\_ WOOD  
\_\_\_\_ Fine Woodworking                   \_\_\_\_ Wooden Boat  
\_\_\_\_ Home Handyman                      \_\_\_\_ Woodshop News  
\_\_\_\_ Journal of Light Construction      \_\_\_\_ Woodsmith  
\_\_\_\_ Old House Journal                   \_\_\_\_ Woodwork  
\_\_\_\_ Popular Mechanics                   \_\_\_\_ Woodworker  
\_\_\_\_ Popular Science                      \_\_\_\_ Woodworker's Journal  
\_\_\_\_ Popular Woodworking                \_\_\_\_ Workbench  
\_\_\_\_ Other \_\_\_\_\_
3. Which of the following woodworking/remodeling shows do you watch?  
\_\_\_\_ Backyard America                   \_\_\_\_ The New Yankee Workshop  
\_\_\_\_ Home Time                            \_\_\_\_ This Old House  
\_\_\_\_ The American Woodworker        \_\_\_\_ Woodwright's Shop  
\_\_\_\_ Other \_\_\_\_\_
4. What is your annual household income?  
\_\_\_\_ \$20,000-\$29,999                      \_\_\_\_ \$60,000-\$69,999  
\_\_\_\_ \$30,000-\$39,999                      \_\_\_\_ \$70,000-\$79,999  
\_\_\_\_ \$40,000-\$49,999                      \_\_\_\_ \$80,000-\$89,999  
\_\_\_\_ \$50,000-\$59,999                      \_\_\_\_ \$90,000 +
5. What is your age group?  
\_\_\_\_ 20-29                                    \_\_\_\_ 50-59  
\_\_\_\_ 30-39                                    \_\_\_\_ 60-69  
\_\_\_\_ 40-49                                    \_\_\_\_ 70 +
6. How long have you been a woodworker?  
\_\_\_\_ 0 - 2 Years                              \_\_\_\_ 8 - 20 Years  
\_\_\_\_ 2 - 8 Years                              \_\_\_\_ 20+ Years
7. How would you rank your woodworking skills?  
\_\_\_\_ Simple                                  \_\_\_\_ Advanced  
\_\_\_\_ Intermediate                            \_\_\_\_ Master Craftsman
8. What stationary woodworking tools do you own? Check all that apply.  
\_\_\_\_ Air Compressor                      \_\_\_\_ Panel Saw  
\_\_\_\_ Band Saw                                \_\_\_\_ Planer  
\_\_\_\_ Drill Press                               \_\_\_\_ Power Feeder  
\_\_\_\_ Drum Sander                            \_\_\_\_ Radial Arm Saw  
\_\_\_\_ Dust Collector                          \_\_\_\_ Shaper  
\_\_\_\_ Horizontal Boring Machine          \_\_\_\_ Spindle Sander  
\_\_\_\_ Jointer                                   \_\_\_\_ Table Saw  
\_\_\_\_ Lathe                                      \_\_\_\_ Vacuum Veneer Press  
\_\_\_\_ Mortiser                                 \_\_\_\_ Wide Belt Sander
9. \_\_\_\_\_ Other \_\_\_\_\_  
How many of your woodworking machines are Grizzly? \_\_\_\_\_
10. Which benchtop tools do you own? Check all that apply.  
\_\_\_\_ 1" x 42" Belt Sander                      \_\_\_\_ 6" - 8" Grinder  
\_\_\_\_ 5" - 8" Drill Press                        \_\_\_\_ Mini Lathe  
\_\_\_\_ 8" Table Saw                              \_\_\_\_ 10" - 12" Thickness Planer  
\_\_\_\_ 8" - 10" Bandsaw                        \_\_\_\_ Scroll Saw  
\_\_\_\_ Disc/Belt Sander                        \_\_\_\_ Spindle/Belt Sander  
\_\_\_\_ Mini Jointer  
\_\_\_\_ Other \_\_\_\_\_
11. How many of the machines checked above are Grizzly? \_\_\_\_\_
12. Which portable/hand held power tools do you own? Check all that apply.  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_
13. What machines/supplies would you like Grizzly Industrial to carry?  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_
14. What new accessories would you like Grizzly Industrial to carry?  
\_\_\_\_ Builders Hardware                      \_\_\_\_ Hand Tools  
\_\_\_\_ Fasteners                                \_\_\_\_ Wood Components  
\_\_\_\_ Other \_\_\_\_\_
15. What other companies do you purchase your tools and supplies from?  
\_\_\_\_\_  
\_\_\_\_\_
16. Do you think your purchase represents good value?  
\_\_\_\_ Yes                                        \_\_\_\_ No
17. Would you recommend Grizzly Industrial to a friend?  
\_\_\_\_ Yes                                        \_\_\_\_ No
18. Would you allow us to use your name as a reference for Grizzly customers in your area? **Note: We never use names more than three times.**  
\_\_\_\_ Yes                                        \_\_\_\_ No
19. Comments: \_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_

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GRIZZLY INDUSTRIAL, INC.  
P.O. BOX 2069  
BELLINGHAM, WA 98227-2069



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Send a Grizzly Catalog to a friend:

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Street	_____
City	_____ State _____ Zip _____

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